

Date: Monday, 4/16/2007 2:25:07 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SPACEPOD ASSEMBLY RH/ DSI 9335
Job Number : 31769	
Estimate Number : 12779	
P.O. Number : N/A	Part Number : D350600242
This Issue : 4/16/2007 S.O. No. : N/A	Drawing Number : D3188REV.E, ICA REV. 2
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : SMALL /MED FAB	Drawing Revision : E, 2
Previous Run : 31812	Material : N/A
Written By : <u>                    </u>	Due Date : 5/5/2007 Qty: 1 Um: Each
Checked & Approved By : <u>                    </u>	
Comment : Est Rev: A 07.03.07 new issue EC	
est rev B 07.04.16 reformat, D3188 rev.E EC	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
-----	----	------------------



Comment: DOCUMENT CONTROL

Photocopy bluefile and type labels as per PPP D350-600-242 CHG001

KS 07-04.17

2.0	31769A	SPACEPOD BODY RH
-----	--------	------------------



Comment: Sub-Component SPACEPOD BODY RH

B 30044

ml 07/04/17

3.0	31769B	SPACEPOD DOOR RH
-----	--------	------------------



Comment: Sub-Component SPACEPOD DOOR RH

B 30034 (30034) ml 07/04/17

4.0	D31872	Spacepod Floor
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3187-2 Floor B 25405

1 D3186-4 Door (ref) N/A 31769B

1 D3188-2 Body(ref) N/A

ml 07/04/17

5.0 A	ALS41032130	/ALS 1032-130	Insert
-------	-------------	---------------	--------



Comment: Qty.: 28.0000 Each(s)/Unit Total : 28.0000 Each(s)

insert

batch: M103962 X 26

/ALS 1032-130 M 102475 X 2

5.0 B

AN 3235

AN3235-020-935 Washers x 8 M103962

PTO

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07/04/17	5.0 B	These Washers missing on - 242 only should add on listing  Permanent change	mul	07-04-27			07/04/26

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Transfer drill (#30) from D3187-1 into D3188-1.

2-Open holes in D3188-1 body floor to Ø0.297".

3-Install inserts in D3188-1 as per Dwg D3188.

4-Open holes in D3187-1 aluminum floor to 0.250" per dwg D3187

5-Deburr holes in D3187-1

*ml* 07/04/17

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*SB* 07/04/17 ①

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

\*\*\*\*\*D3187-1 floor only\*\*\*\*\*

Chemical Conversion Coat as per QSI 005 4.1

*M-L* 07/04/18

①

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

\*\*\*\*\*D3187-1 floor only\*\*\*\*\*

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

*ESJ* 07-04-19 ①

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*M-L* 07/04/19

11.0

D2986

Black Neoprene foam .125



Comment: Qty.: 5.9010 sf(s)/Unit Total : 5.9010 sf(s)

neoprene foam

batch:

*B30632*

*✓ ml* 07/04/24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number: 31769

Part Number: D350600242

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Cut D2986 Neoprene Foam per template D2986T1

ml 07/04/24

13.0

QC5

INSPECT WORK TO CURRENT STEP



N/A ml

Comment: INSPECT WORK TO CURRENT STEP

14.0

D30153

Lock Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Lock Nut

batch: B30169



15.0

D35547

BALL STUD



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

BALL STUD

B 30210 ✓



16.0

D35672

DECAL



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

DECAL

batch: B31128



17.0

D2237

Striker Plate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Batch: ~~B28288~~ B30680



18.0

MS20426AD45

Rivet



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Batch: m4067



ml 07/04/17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number: 31769

Part Number: D350600242

Job Number:



Seq. #:

Machine Or Operation:

Description :

19.0

D35381

HINGE BRACKET



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)  
HINGE BRACKET  
batch: B30866

✓

20.0

D2179

Doubler



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)  
Pick:  
Batch: B21490

✓

21.0

AN526C832R24

screw



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)  
Screw  
batch: M103574

✓

22.0

AN960JD8

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)  
Washer  
batch: M102455

✓

23.0

MS21042L08

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)  
Nut  
batch: M103830

✓

24.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

\*\*\*\*This step separates hardware, previous steps is for body & floor\*\*\*\*

n/a ml

25.0

MS270390811

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)  
Screw  
batch: M103585

✓ ml 07/04/17

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number: 31769

Part Number: D350600242

Job Number:



Seq. #:

Machine Or Operation:

Description :

26.0

AN960JD8

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

batch:

*M102455*



27.0

NAS1515H3

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

batch:

*M100993*



28.0

MS21042L08

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Nut

batch:

*M103830*



29.0

D2464

3/4 Seal



Comment: Qty.: 11.3400 f(s)/Unit Total : 11.3400 f(s)

3/4 Seal

Cut 127.00" long

batch:

*B30681*



30.0

D35672

DECAL



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

DECAL

batch:

*B31128*



31.0

D2586

Door Latch



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Door Latch

batch:

*B29021*



32.0

D2585

Latch Clamp



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Latch Clamp

batch:

*B30814*



*ml 07/04/17*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Part Number: D350600242

Job Number:



Seq. #:

Machine Or Operation:

Description :

33.0

D2621

Latch Plate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Latch Plate

batch: B29995



34.0

MS27039115

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Screw

batch: M18057



35.0

AN960JD10

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

batch: M15829



36.0

MS21042L3

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Nut

batch: M102658



37.0

D28571

Hinge Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Hinge Bracket

batch: B29051



38.0

D28572

Hinge Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Hinge Bracket

batch: B29022



39.0

D2228

Backing Plate



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Backing Plate

batch: M30679

✓ mld 07/04/17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number: 31769

Part Number: D350600242

Job Number:



Seq. #:	Machine Or Operation:	Description :
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40.0	AN526C832R10	Screw
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Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)  
Screw  
batch: M103585



41.0	AN960JD8	Washer
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Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)  
Washer  
batch: M103492



42.0	MS21042L08	Nut
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Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)  
Nut  
batch: M103830



43.0	D35571	BRACKET
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
BRACKET  
batch: B30644



44.0	AN526C832R14	Screw
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)  
Screw  
batch: M9216



45.0	AN526C832R10	Screw
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)  
Screw  
batch: M103585

✓ M1007/04/17

46.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble D3186-1 door with D3188-1 body as per Dwg ICA-D350-600

\*\*\*Hardware on previous steps is for door ass'y\*\*\*\*

1-Drill and plug section I-I and J-J of dwg D3188 p.11 using Hysol 934NA with milled fibres 10% to weight.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number: 31769

Part Number: D350600242

Job Number:



Seq. #:

Machine Or Operation:

Description :

A/R Hysol batch: M103922 expire date: mar 2008  
A/R Milled fibres batch: M100859

2-Attach Neoprene Foam to floor using Contact Cement  
A/R Contact Cement Batch: 102565

*M-L 07/04/25*

47.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*M-L 07/04/26 (1)*

48.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



*(1)*

Comment: HAND FINISHING RESOURCE #1

Wing Walk Spacepod top surface of Pod as per Dwg D3188 & QSI 005 4.4  
Batch: M103707

*M-L 07/04/18*

49.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: Inspect Wing Walk

*M-L 07/04/25*

50.0

K10021

Spacepod Hardware Kit (-241)



Comment: Qty.: 1.0000 (s)/Unit Total: 1.0000 (s)

*B31842*

51.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

52.0

D350600449

SWITCH RELOCATION KIT



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)  
SWITCH RELOCATION KIT

*B31898 1*

53.0

D2985

Label



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Label

batch: B27863

*Pc 7/4/26*

*-64.0*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Part Number: D350600242

Job Number:



Seq. #:

Machine Or Operation:

Description :

54.0

D35471

BRACKET



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
BRACKET  
batch: B31124 ✓

55.0

D35501

STRUT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
STRUT  
batch: B31148 ✓

56.0

D35527

CARBON STEEL GAS SPRING



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
CARBON STEEL GAS SPRING  
batch: B31197 ✓

57.0

D35547

BALL STUD



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
BALL STUD  
batch: B30210 ✓

58.0

AN960JD516

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)  
Washer  
batch: M102519 ✓

59.0

D30153

Lock Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
Lock Nut  
batch: B30169 ✓

60.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1  
Identify and pack for shipping as per PPP D350-600-141  
Location: \_\_\_\_\_  
PPP Rev: \_\_\_\_\_

Inspected: EP 04/14/26 PO 7/4/26 207104/260  
Rev B EP 04/17/26 50

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/04/27  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number:



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Machine Or Operation:

Description :

61.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Do 7/16/27

Job Completion



U 8-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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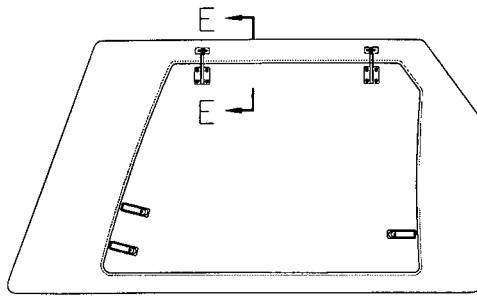


FIGURE 3. LOOKING AT OUTSIDE OF  
D350-600-145 DOOR  
(D350-600-146 SIMILAR AND OPPOSITE)

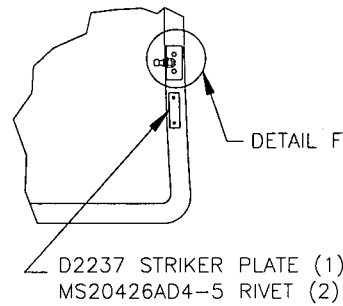


FIGURE 4. TYPICAL DOOR FRAME (AFT EDGE)

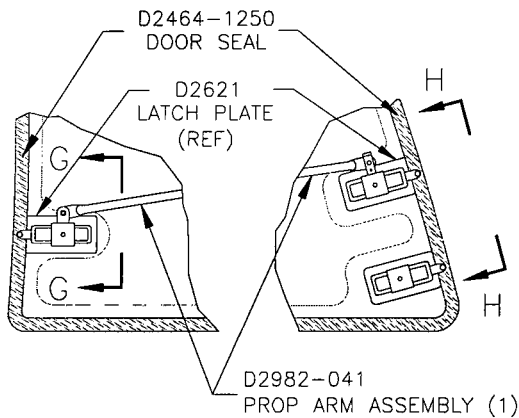
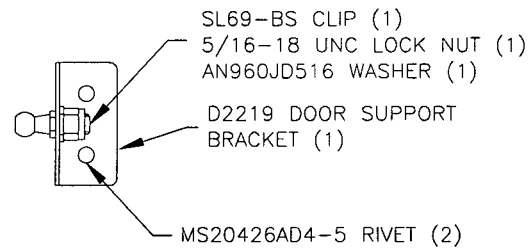


FIGURE 5. LOOKING AT TYPICAL INSIDE  
OF D350-600-145/-146 DOOR



DETAIL F

TC Accepted

MAY 07 2003

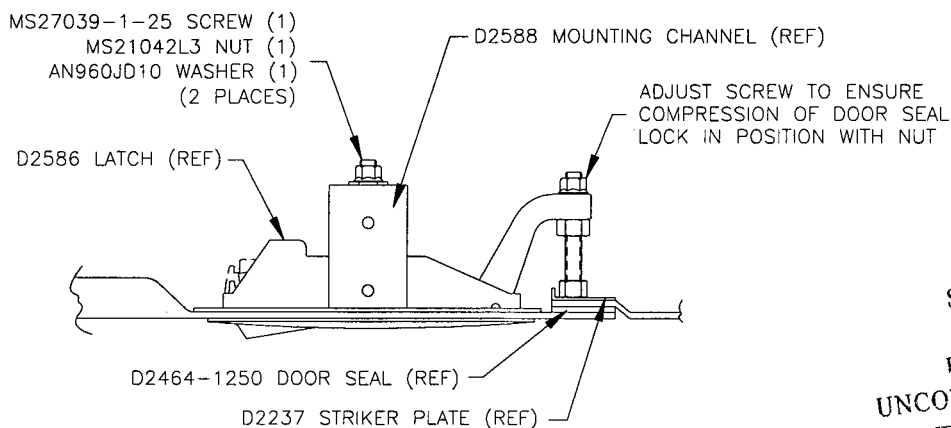
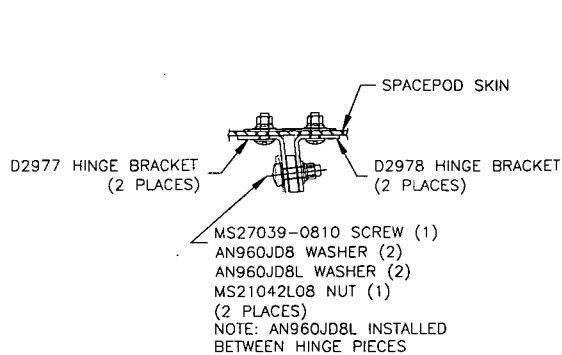


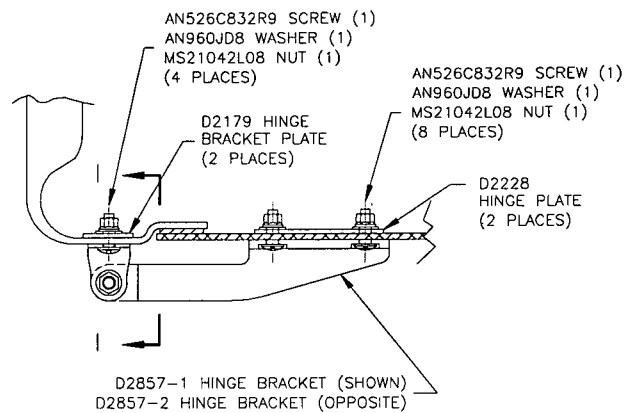
FIGURE 6. TYPICAL LATCH INSTALLATION

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 31769

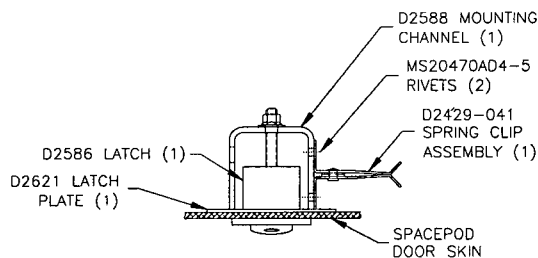
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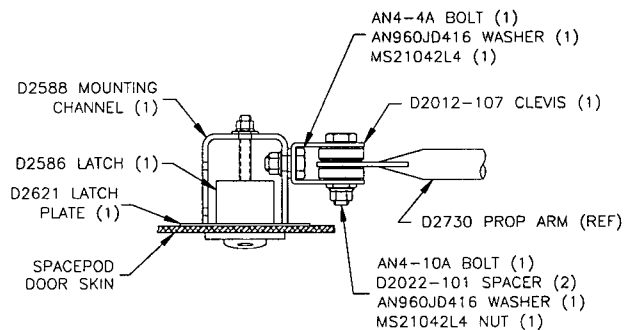
SECTION I-I: HINGE BRACKET



SECTION E-E: HINGE DETAIL FROM FIGURE 3



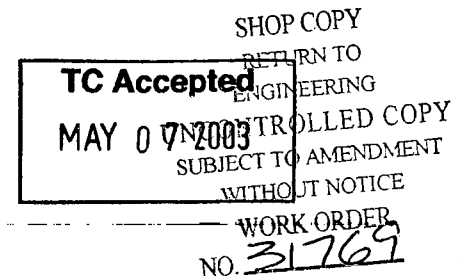
SECTION H-H: FWD LATCH



SECTION G-G: AFT LATCH

## 25.3 SPACEPOD™ REMOVAL

1. Remove D350-600-045/-145 or -046/-146 door.
2. Remove battery shelf and wiring covers as applicable.
3. Loosen floor and D2174-041 bracket fasteners shown in section A-A, B-B, and C-C of Figure 2. Leave inserts in the compartment floor.
4. Remove **Spacepod™** body from the compartment.
5. Remove D2174-041 brackets.
6. Re-install battery shelf and wiring covers.
7. Re-install outboard tiedown "D" rings.
8. Re-install door latch tiedown brackets in the compartment floor.
9. Re-install baggage retaining net.
10. Re-install original side baggage compartment door.



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JB	CB	HAWKESBURY, ONTARIO, CANADA...
CHECKED	APPROVED	REV. E
CE	[Signature]	D3188
DATE	TITLE	SHEET 1 OF 11
07.04.02	SPACEPOD BODY	SCALE
		NTS
A	03.04.03	NEW ISSUE
B	06.10.06	UPDATED DWG TO MATCH PRODUCT ADDED D3188-1M/-2M/-3M/-5/-6/-7
C	06.12.13	REMOVED D0600-XXX LABELS
D	07.02.22	UPDATE DIMENSIONS
E	07.04.02	ADD. HYSOL/FIBER OPTION ON SHEET 11

**GENERAL NOTES:**

- 1) REFERENCE DIMENSIONS MATCH AIRCRAFT CONTOUR AND DOOR OPENING
- 2) LAMINATE PER DART QSI 006. LAMINATION SCHEDULE PER THIS DRAWING
- 3) MATERIALS:

RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40

FIBER: 9.7 oz 7781 WEAVE "S" GLASS (9 oz SATIN)  
12 oz UNIDIRECTIONAL FIBERGLASS ("12 oz UNIDIRECTIONAL")  
18 oz ROVING "E" GLASS (18 oz CLOTH)  
OWENS CORNING MILLED FIBERS, "E" GLASS  
3M K20 GLASS BUBBLES

FOAM: A500 CORE CELL  
OR DIVINYCELL  
OR AIREX  
OR KLEGECELL  
FILL VOIDS IN FOAM WITH PASTE MADE FROM MILLED FIBERS & RESIN

- 4) MOLD SCHEDULE:

PART	LAYUP	TRIM AND DRILL
D3188-1M/-1/-5	DT8003	DT8501
D3188-2M/-2/-6	DT8004	DT8502
D3188-3M/-3/-7	DT8500	DT8500

- 5) APPLY ANTI-SKID PAINT TO TOP SURFACE OF PODS PER QSI 005 4.4
- 6) FINISH: INSIDE/OUTSIDE WITH GREY DUPONT HIGHBUILD PRIMER 1144-S

ALL DIMENSIONS ARE IN INCHES

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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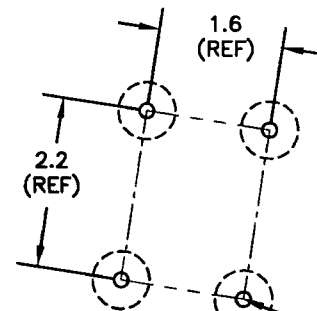
**DART**

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DATE	07.04.02	DRAWING NO.	D3188	REV. E
		TITLE	SPACEPOD BODY	SHEET 2 OF 11
				SCALE
				NTS

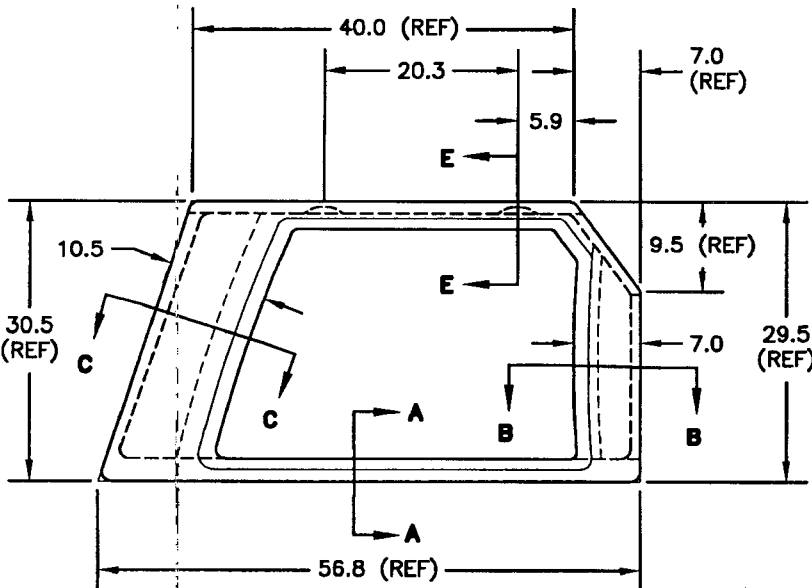
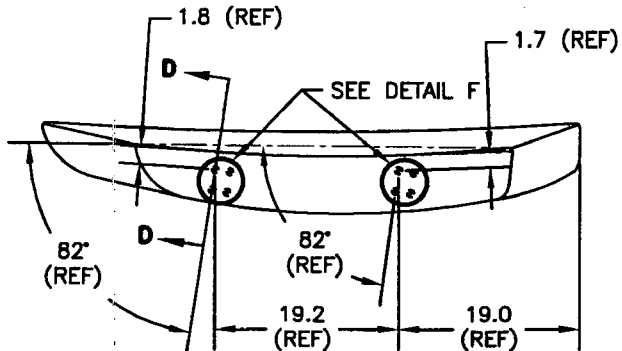
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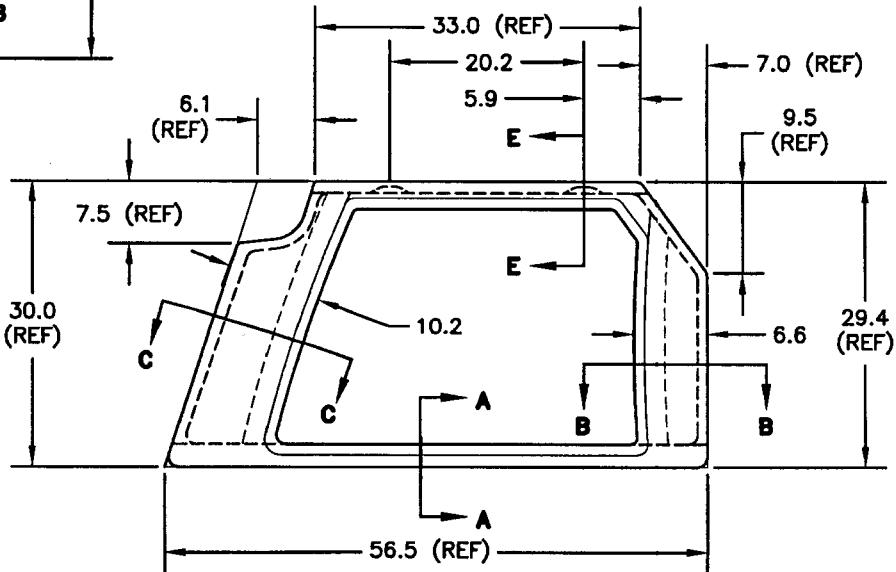
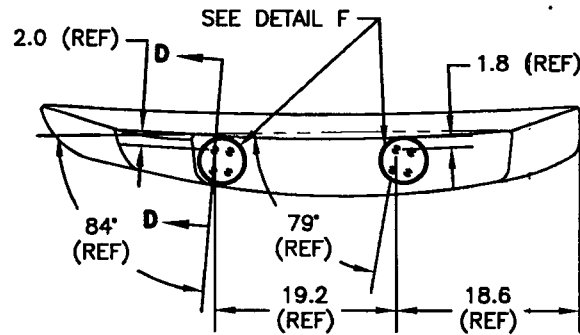
INSTALL  
D2213 SPACER  
(8 PLACES)  
(SEE SECTION D-D)



**DETAIL F**



**D3188-1M SPACEPOD BODY**



**D3188-3M SPACEPOD BODY**

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**D3186-1M/-3M NOTES:**

- 1) REFERENCE DIMENSIONS ARE FROM DT8003/DT8500 AND DT8501.
- 2) SEE SHEET #4 FOR SECTION VIEWS.

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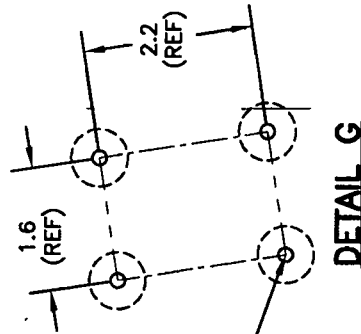


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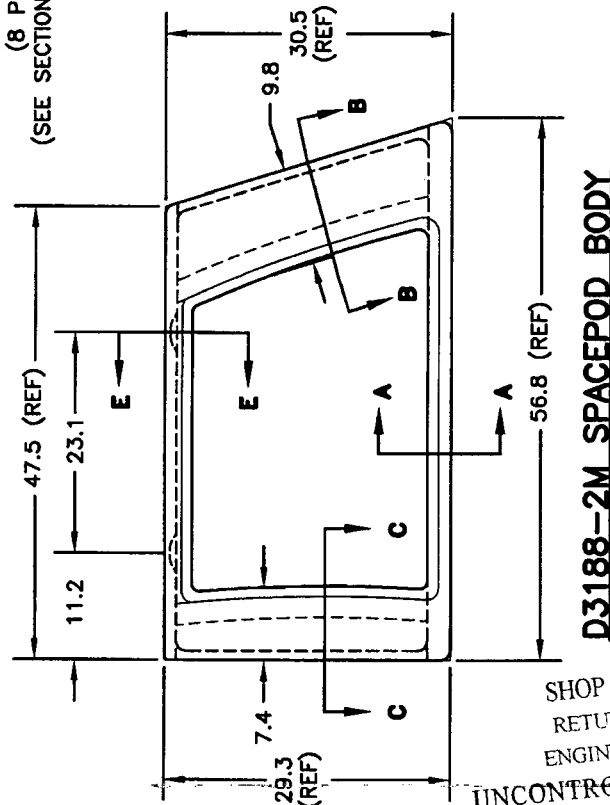
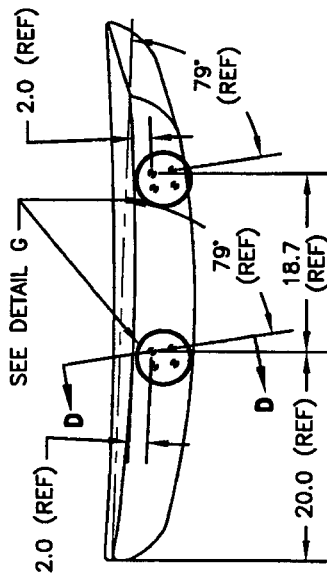
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DATE <b>07.04.02</b>	TITLE <b>SPACEPOD BODY</b>		SCALE NTS

RELEASED

07.04.02 **[Signature]**



INSTALL  
D2213 SPACER  
(8 PLACES)  
(SEE SECTION D-D)



**D3188-2M SPACEPOD BODY**

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D3186-2M NOTES:  
1) REFERENCE DIMENSIONS ARE FROM DT8004 AND DT8502.  
2) SEE SHEET #4 FOR SECTION VIEWS.

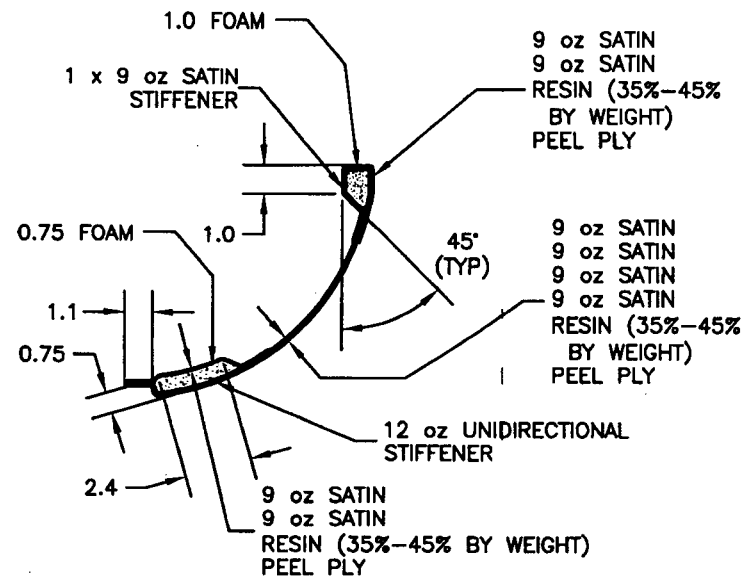
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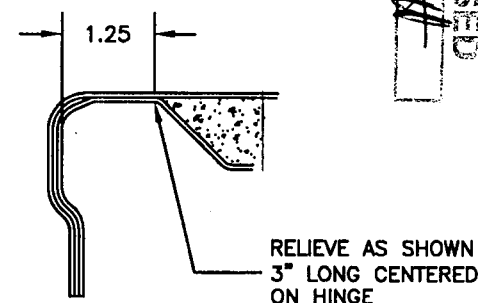
# DART

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DATE	07.04.02	TITLE	SPACEPOD BODY	SHEET 4 OF 11	REV. E
		SCALE	NTS		

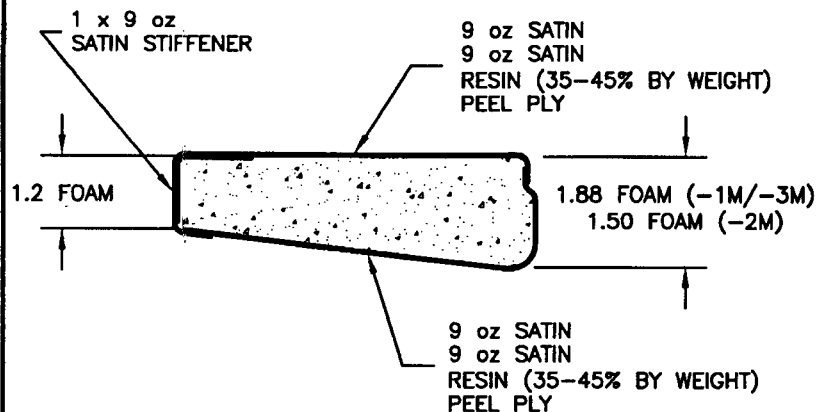
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07.04.01



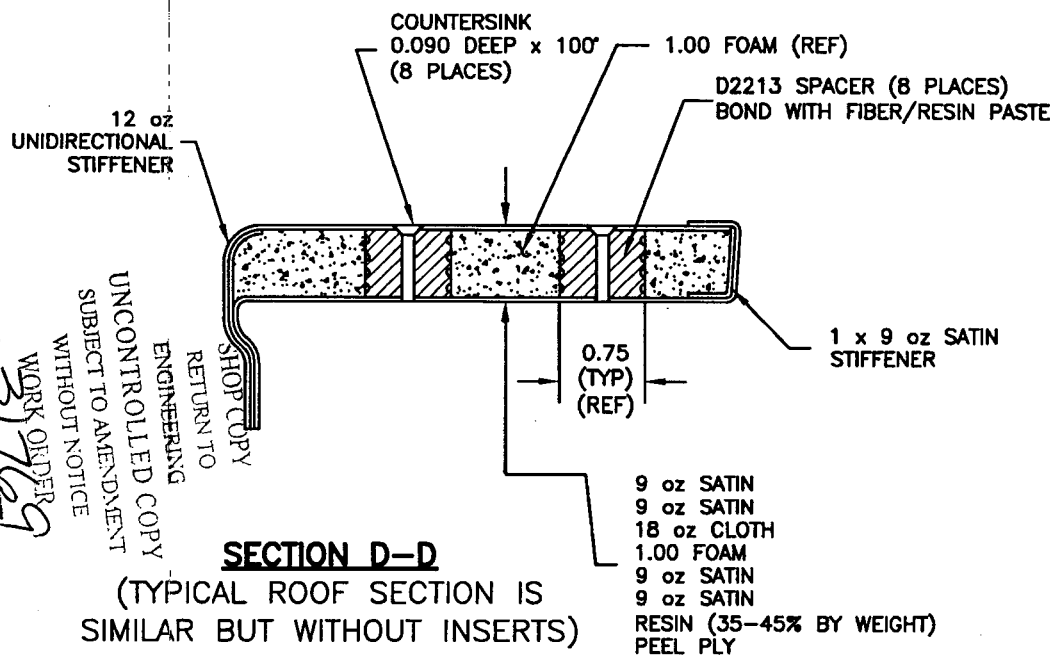
**SECTION B-B**  
(SECTION C-C OPPOSITE)



**SECTION E-E**  
(2 PLACES PER POD)



**SECTION A-A**  
(TYPICAL FLOOR SECTION)



**SECTION D-D**  
(TYPICAL ROOF SECTION IS  
SIMILAR BUT WITHOUT INSERTS)

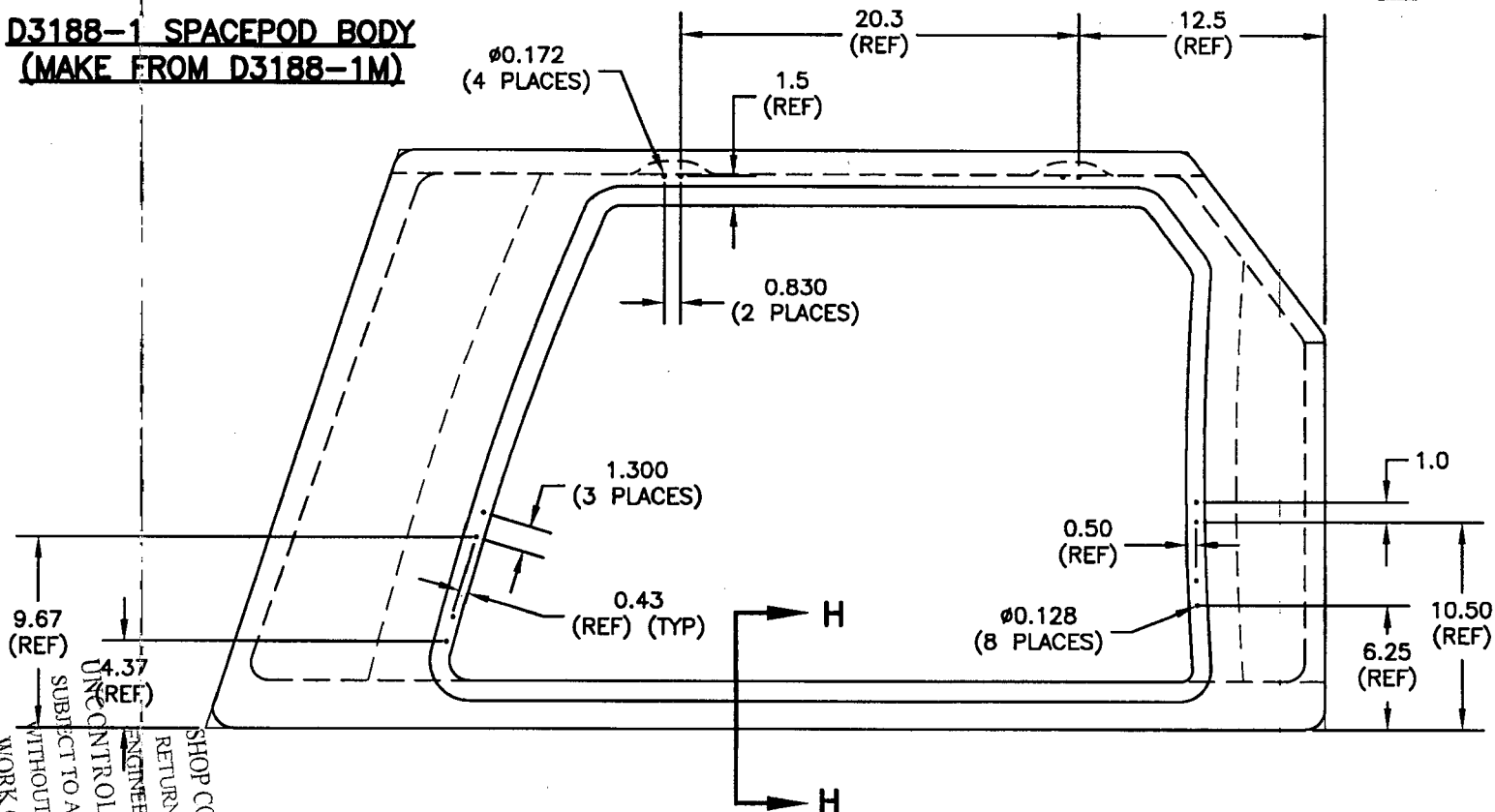
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LE	[Signature]			D3188	SHEET 5 OF 11
DATE	TITLE			SCALE	
07.04.02	SPACEPOD BODY			NTS	

RELEASED

07.04.02

**D3188-1 SPACEPOD BODY  
(MAKE FROM D3188-1M)**



**NOTES:**

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-1 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEW

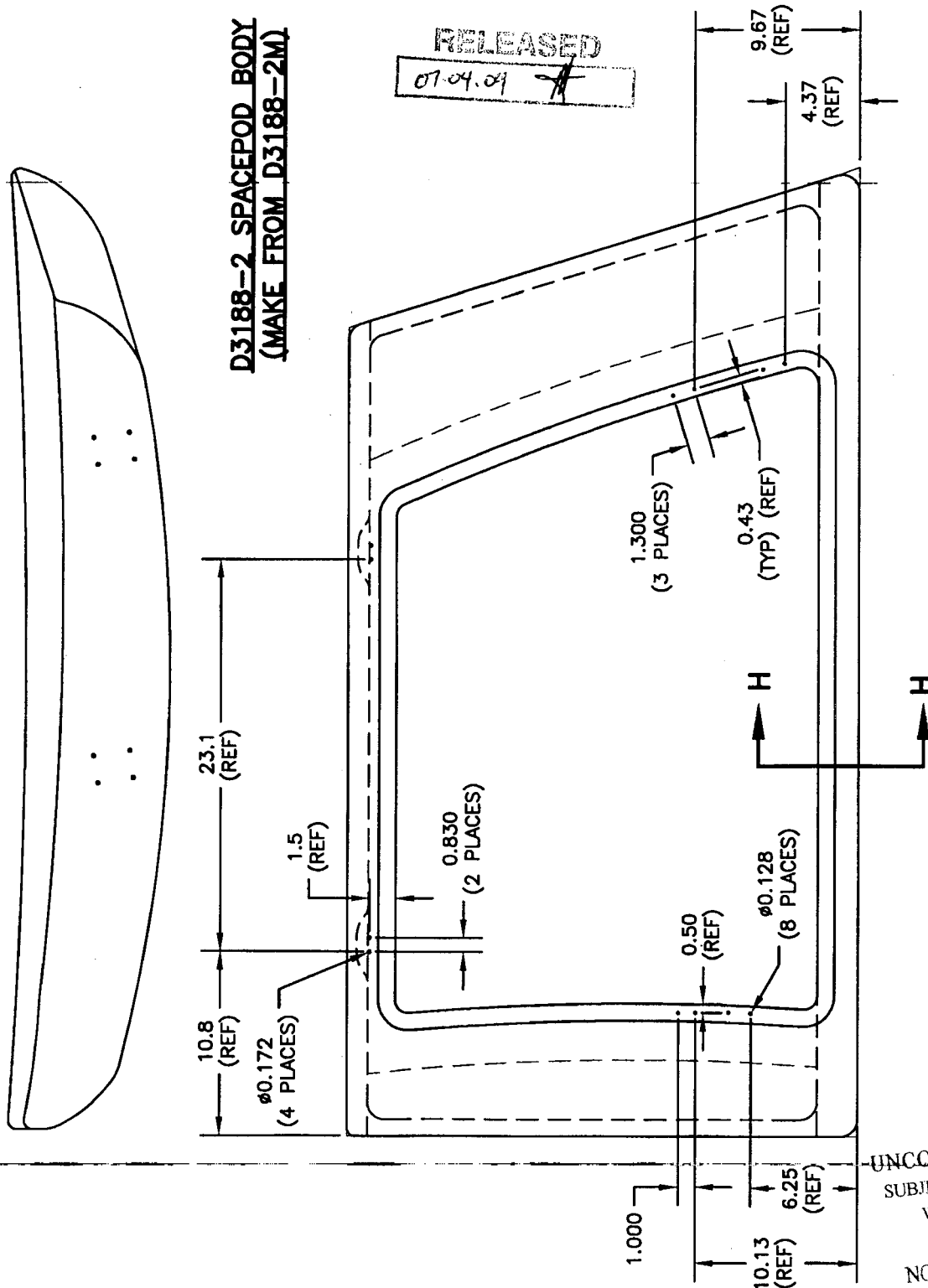
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DATE 07.04.02	TITLE SPACEPOD BODY		SCALE NTS

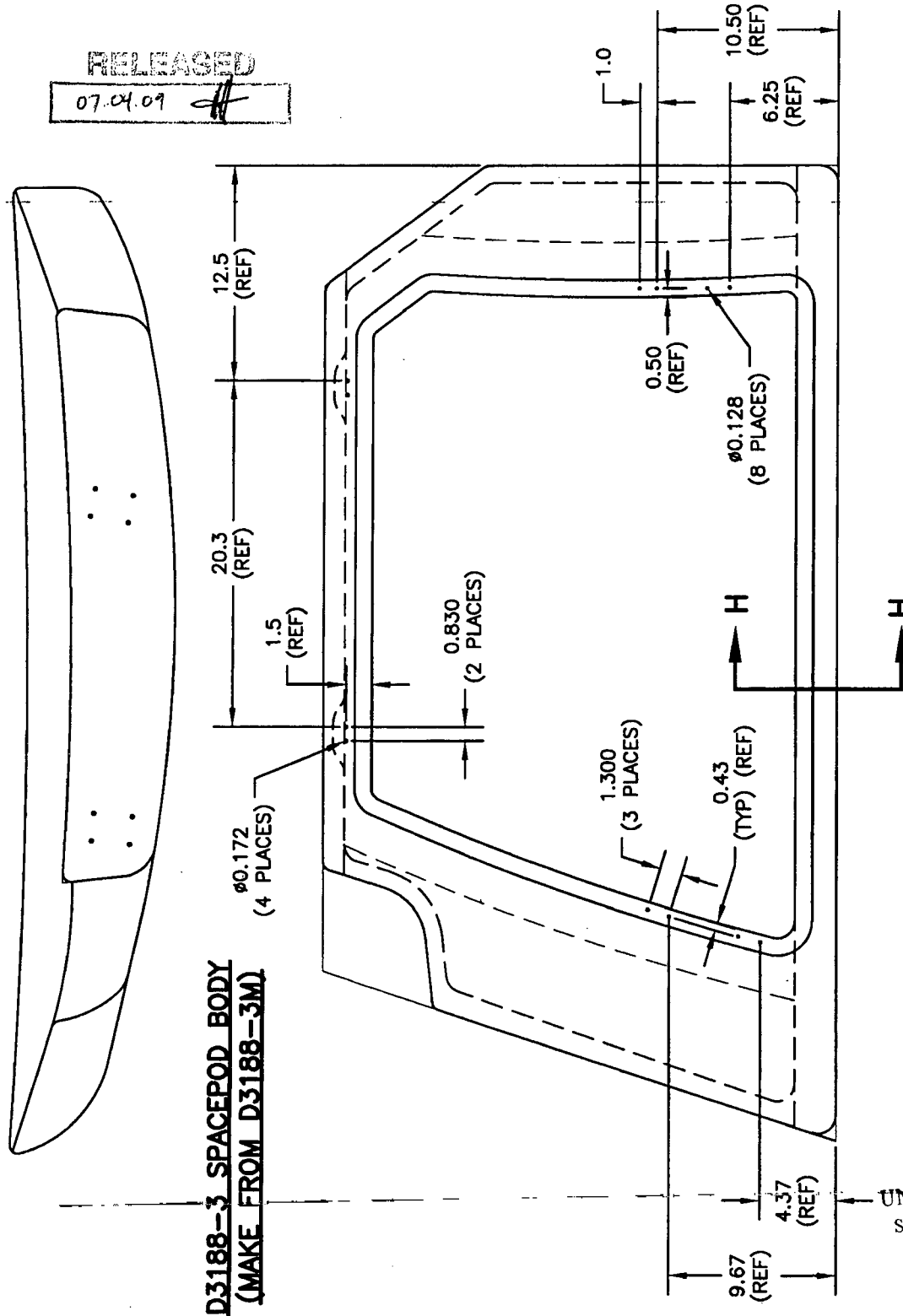


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DATE 07.04.02	TITLE SPACEPOD BODY		SCALE NTS



- NOTES:
- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-1 DOOR DURING ASSEMBLY
  - 2) SEE SHEET #11 FOR SECTION VIEW

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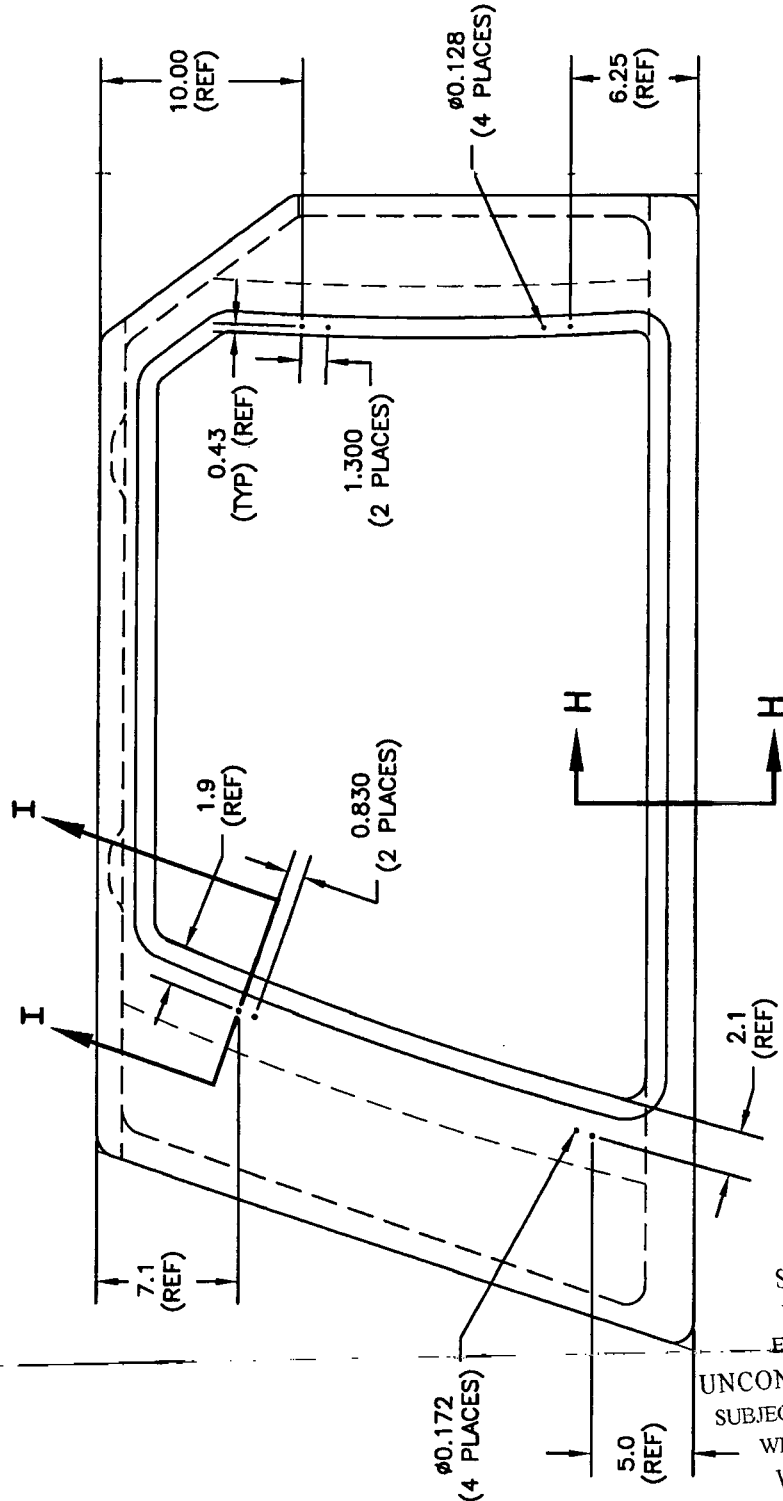
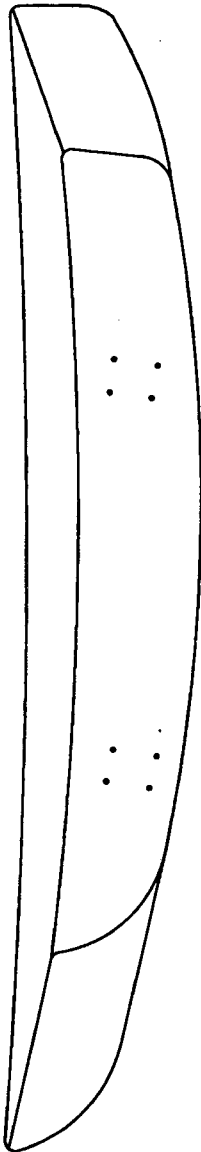
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DATE <b>07.04.02</b>		TITLE <b>SPACEPOD BODY</b>	SCALE NTS

RELEASED

07.04.09 **[Signature]**

**D3188-5 SPACEPOD BODY**  
**(MAKE FROM D3188-1M)**



NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-3 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEWS

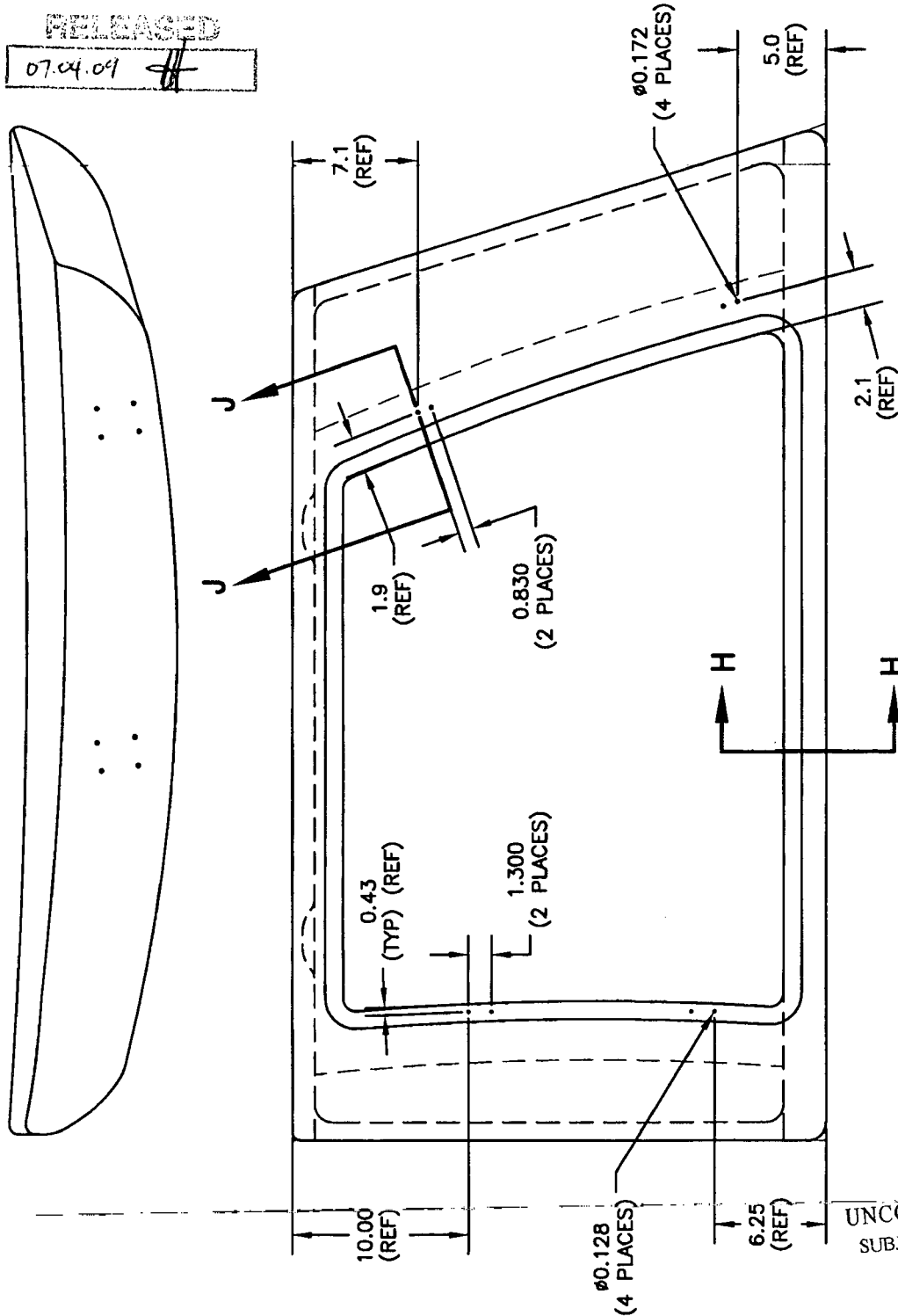
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DATE 07.04.02		TITLE SPACEPOD BODY	SCALE NTS



**D3188-6 SPACEPOD BODY  
(MAKE FROM D3188-2M)**

- NOTES:
- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-4 DOOR DURING ASSEMBLY
  - 2) SEE SHEET #11 FOR SECTION VIEWS

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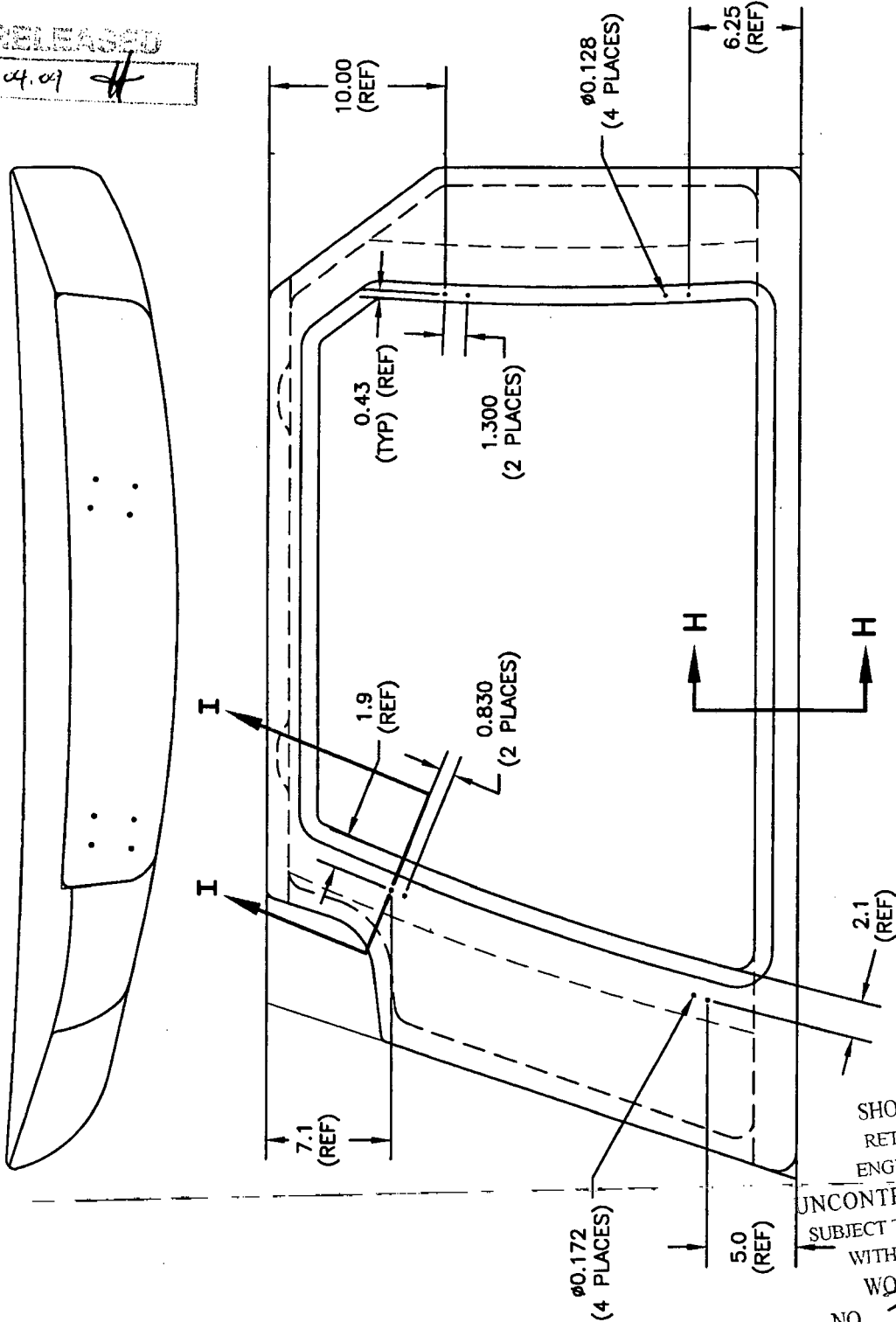
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DATE <b>07.04.02</b>		TITLE <b>SPACEPOD BODY</b>	SCALE NTS

RELEASED

07.04.02

**D3188-7 SPACEPOD BODY  
(MAKE FROM D3188-3M)**



- NOTE:**
- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-3 DOOR DURING ASSEMBLY
  - 2) SEE SHEET #11 FOR SECTION VIEWS

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DATE 07.04.02		TITLE SPACEPOD BODY	SCALE NTS

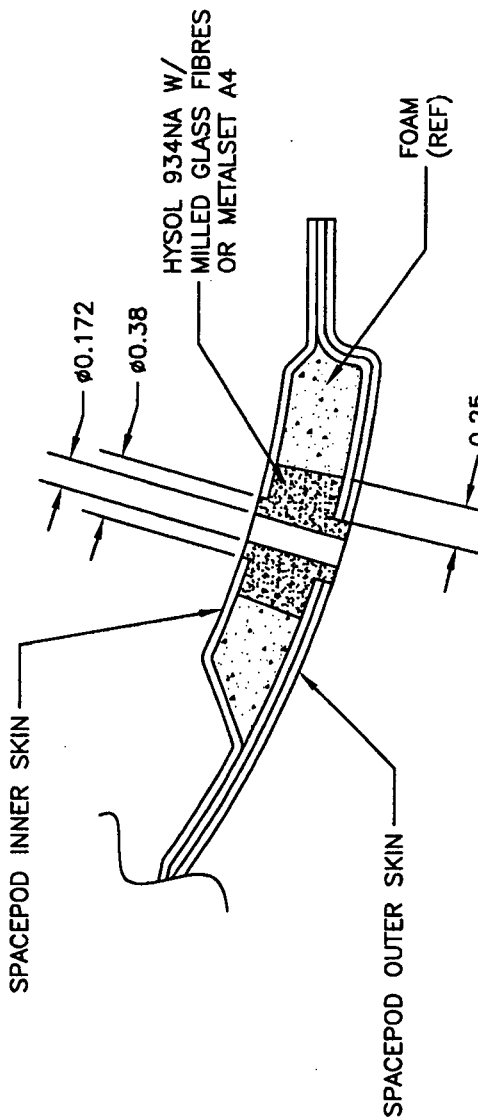
RELEASED

01.04.09 [Signature]

INSTALL AKS7-1032-130  
INSERTS (29 PLACES)  
PER D3188-1T1 (D3188-1/-3/-5/-7)  
OR D3188-2T1 (D3188-2/-6)

FOAM  
(REF)

**SECTION H-H**  
(TYPICAL FLOOR SECTION)



**SECTION I-I**  
(SECTION J-J OPPOSITE)  
(4 PLACES PER POD)

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Date: Monday, 4/16/2007 2:25:14 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SPACEPOD DOOR RH
Job Number	: 31769B		
Estimate Number	: 12636		
P.O. Number	: N/A	Part Number	: D31864
This Issue	: 4/16/2007 S.O. No. : N/A	Drawing Number	: D3186 REV.D
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : SMALL /MED FAB	Drawing Revision	: D
Previous Run	: 31812B	Material	: N/A
Written By	: <u>Kim Johnston</u>	Due Date	: 5/5/2007 Qty: 1 Um: Each
Checked & Approved By	: <u>Kim Johnston</u>		
Comment	: Est Rev: A New Issue 07-01-11 EC est rev.B revD 07.03.07 ec		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	31769B01	SPACEPOD DOOR RH
-----	----------	------------------



w/o 30034



ml 07/04/17

Comment: Sub-Component SPACEPOD DOOR RH

2.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: SMALL &amp; MEDIUM FAB RESOURCE 1

1-Drill holes and cut out slots for latch as per dwg D3186 (D3186-4 detail)

ml 07/04/18

3.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------



Comment: INSPECT WORK TO CURRENT STEP

4.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

ml 07/04/19

5.0	QC21	FINAL INSPECTION/W/O RELEASE
-----	------	------------------------------



①

Comment: FINAL INSPECTION/W/O RELEASE

ml 07/04/27

Job Completion



u 07.04.27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: Yes Date: 07/04/27  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**DART**

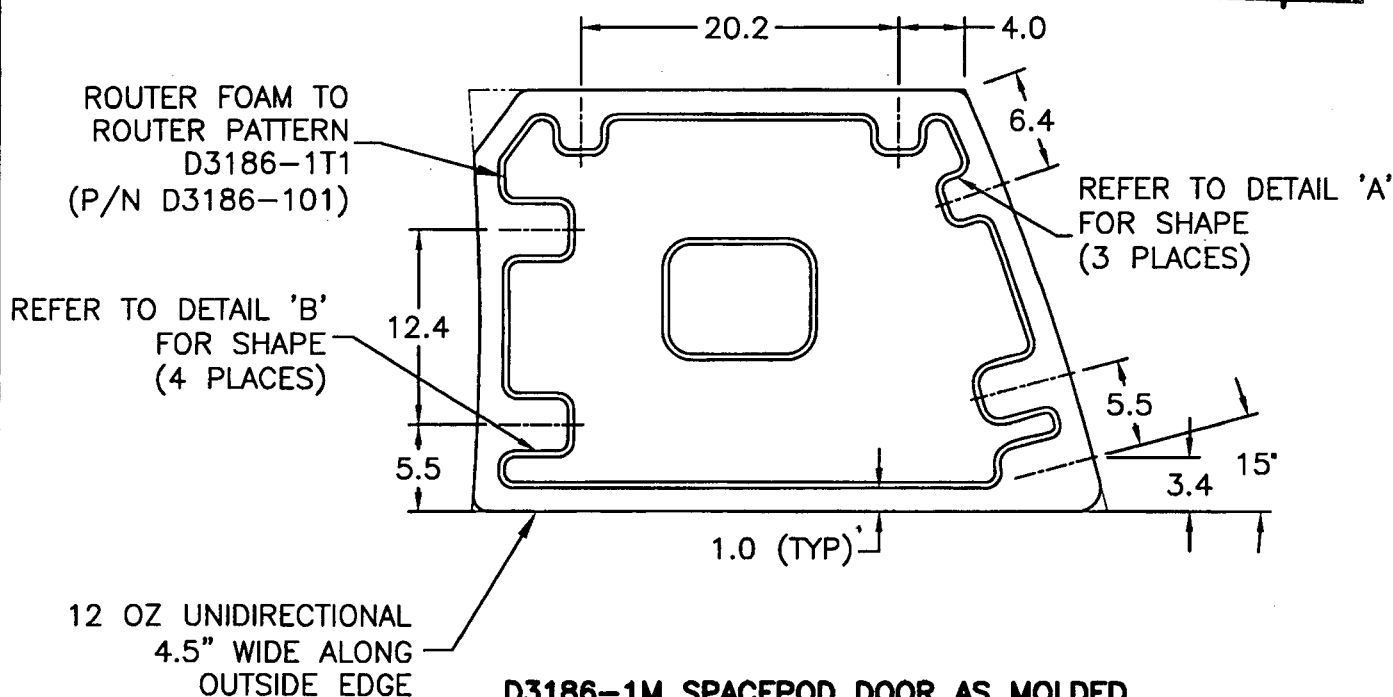
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CHECKED B	APPROVED H	DRAWING NO. D3186	REV. D SHEET 1 OF 5
DATE 07.02.22	TITLE SPACEPOD DOOR		SCALE NTS
A	03.03.27	NEW ISSUE	
B	06.09.25	DIMS UPDATED TO MATCH PRODUCT FOAM PATTERN UPDATED D3186-1M/-2M/-3/-4 ADDED	
C	06.12.13	REMOVED D0600-XXX LABELS	
D	07.02.22	UPDATE DIMENSIONS	

**MAIN LAYUP**

9 OZ SATIN (9 SQ FEET)  
9 OZ SATIN (9 SQ FEET)  
FOAM  
9 OZ SATIN (9 SQ FEET)  
12 OZ UNIDIRECTIONAL  
9 OZ SATIN (9 SQ FEET)  
RESIN (35-45% BY WEIGHT)  
PEEL PLY

**RELEASED**

07.02.27

**D3186-1M SPACEPOD DOOR AS MOLDED****NOTES:**

- 1) USE MOLD DT8005 FOR DOOR LAYUP
- 2) RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
- 3) FOAM: 3/8", A500 CORE-CELL OR DIVINYLCELL OR AIREX OR KLEGECELL
- 4) FIBRE: 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")  
12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
- 5) LAMINATE PER DART QSI 006 4.0
- 6) LAMINATION SCHEDULE PER THIS DRAWING
- 7) FINISH INSIDE/OUTSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S
- 8) ALL DIMENSIONS ARE IN INCHES
- 9) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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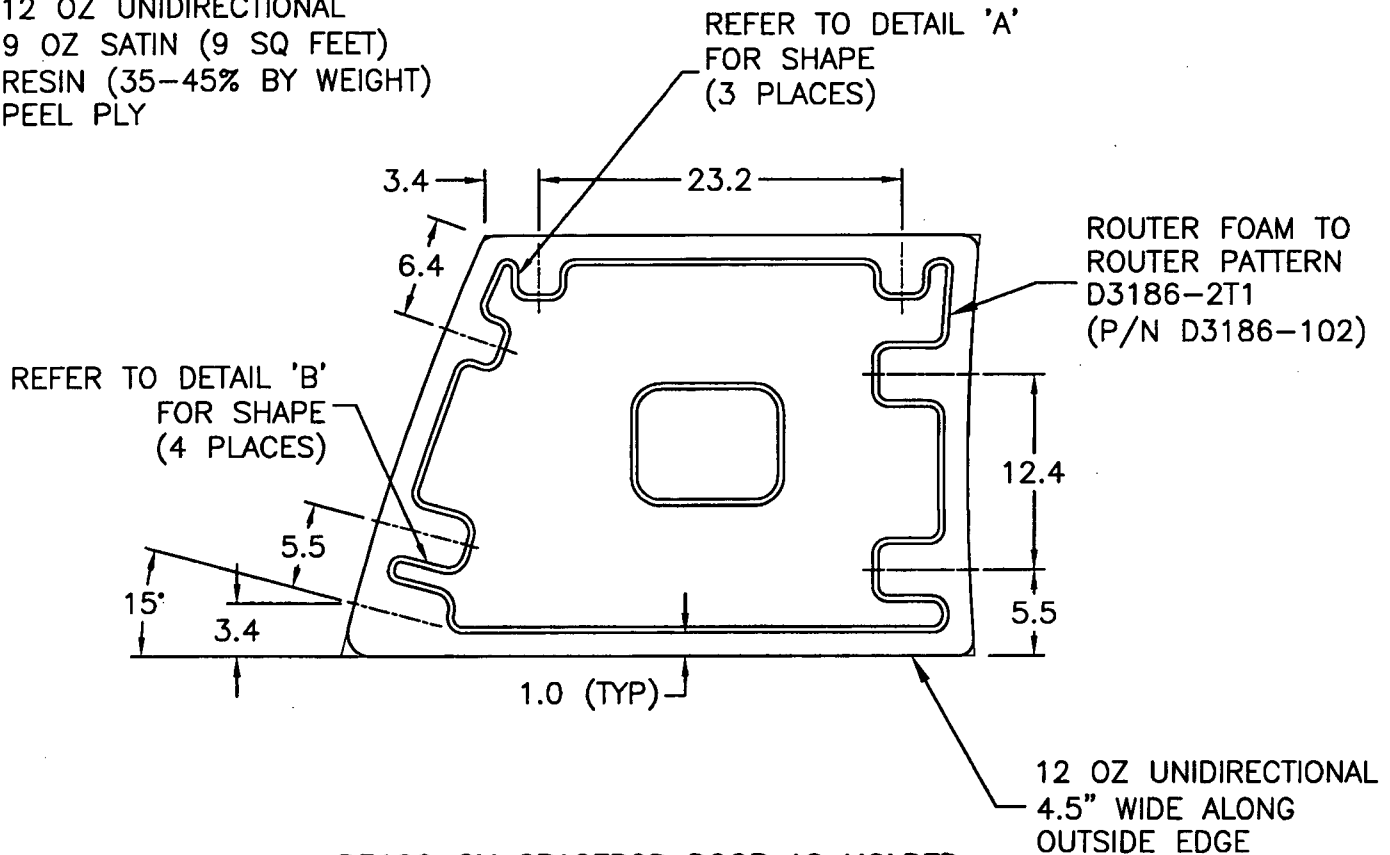
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CHECKED B	APPROVED H	DRAWING NO. D3186	REV. D SHEET 2 OF 5
DATE 07.02.22	TITLE SPACEPOD DOOR		SCALE NTS

**MAIN LAYUP**

9 OZ SATIN (9 SQ FEET)  
9 OZ SATIN (9 SQ FEET)  
FOAM  
9 OZ SATIN (9 SQ FEET)  
12 OZ UNIDIRECTIONAL  
9 OZ SATIN (9 SQ FEET)  
RESIN (35-45% BY WEIGHT)  
PEEL PLY

**RELEASED**

07.02.27 H

**D3186-2M SPACEPOD DOOR AS MOLDED****NOTES:**

- 1) USE MOLD DT8006 FOR DOOR LAYUP
- 2) RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
- 3) FOAM: 3/8", A500 CORE-CELL OR DIVINYCELL OR AIREX OR KLEGECELL
- 4) FIBRE: 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")  
12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
- 5) LAMINATE PER DART QSI 006 4.0
- 6) LAMINATION SCHEDULE PER THIS DRAWING
- 7) FINISH INSIDE/OUTSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S
- 8) ALL DIMENSIONS ARE IN INCHES
- 9) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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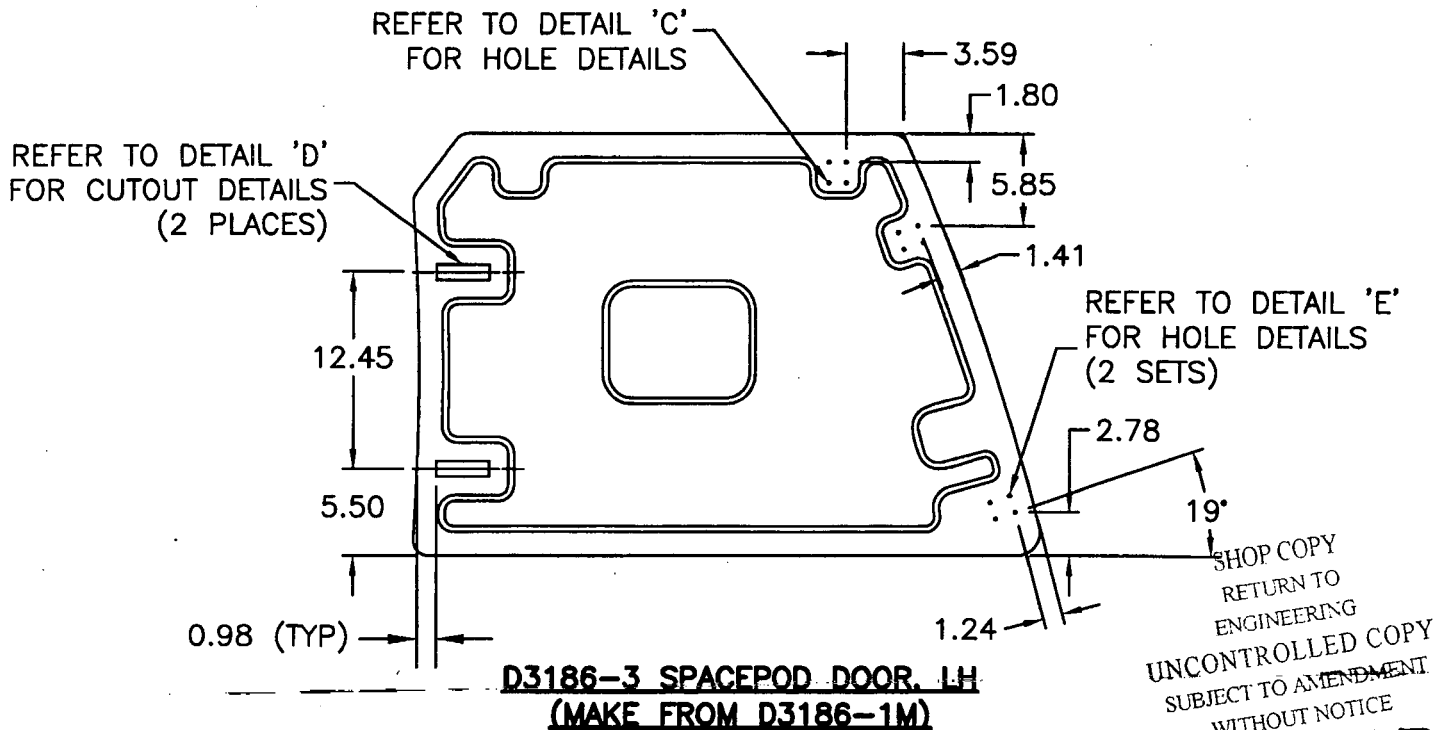
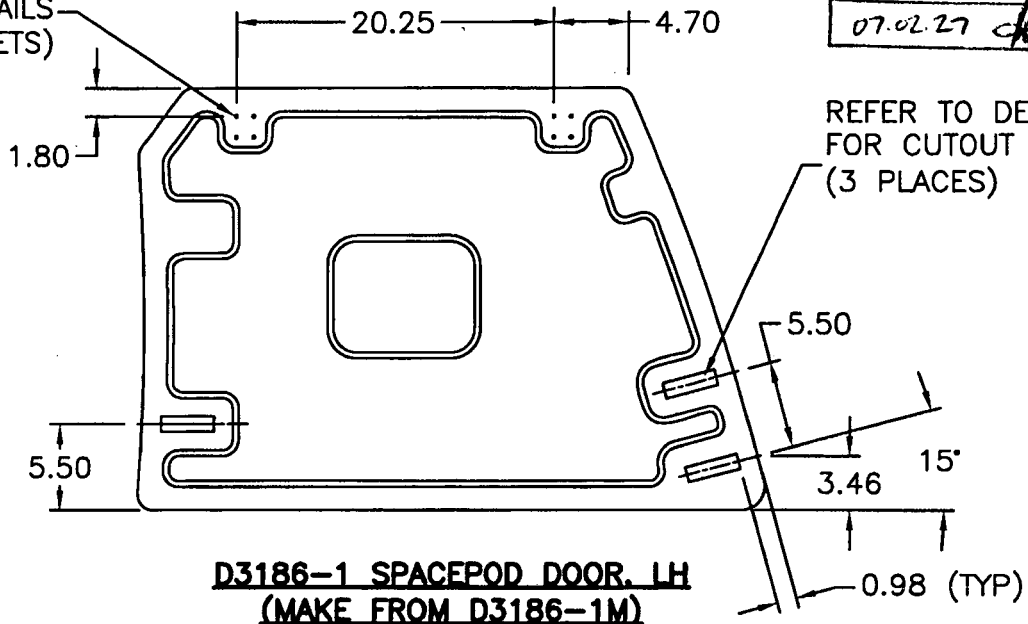
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DATE 07.02.22	TITLE SPACEPOD DOOR		SCALE NTS

REFER TO DETAIL 'C'  
FOR HOLE DETAILS  
(2 SETS)

**NOTES:**

- 1) ALL DIMENSIONS ARE IN INCHES
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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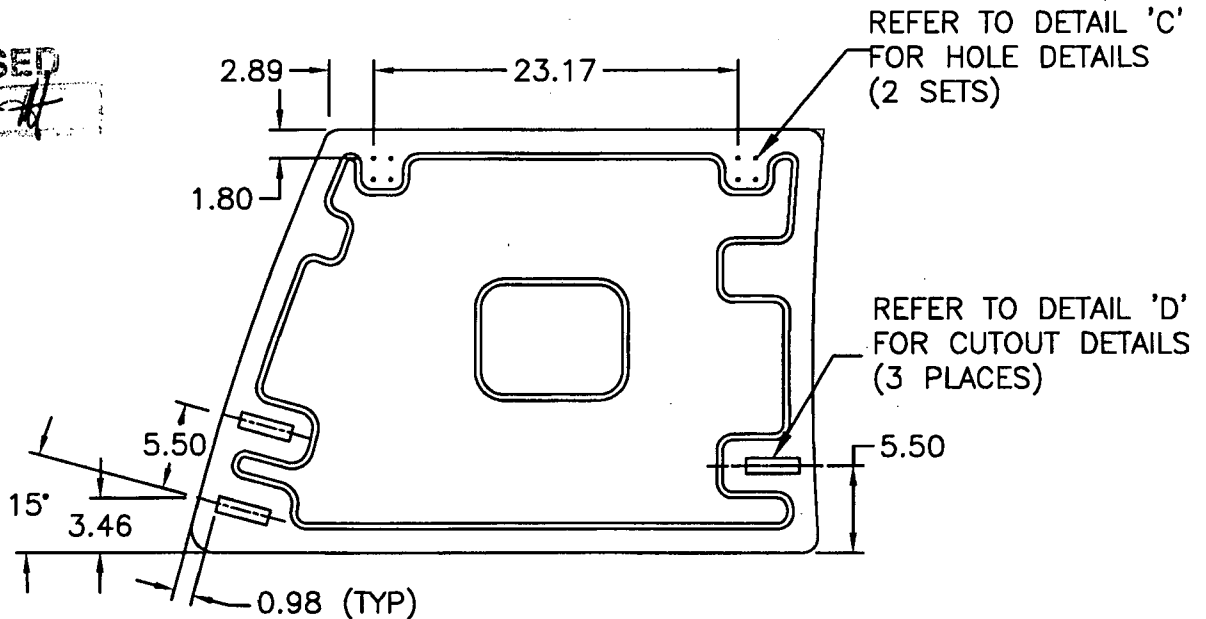
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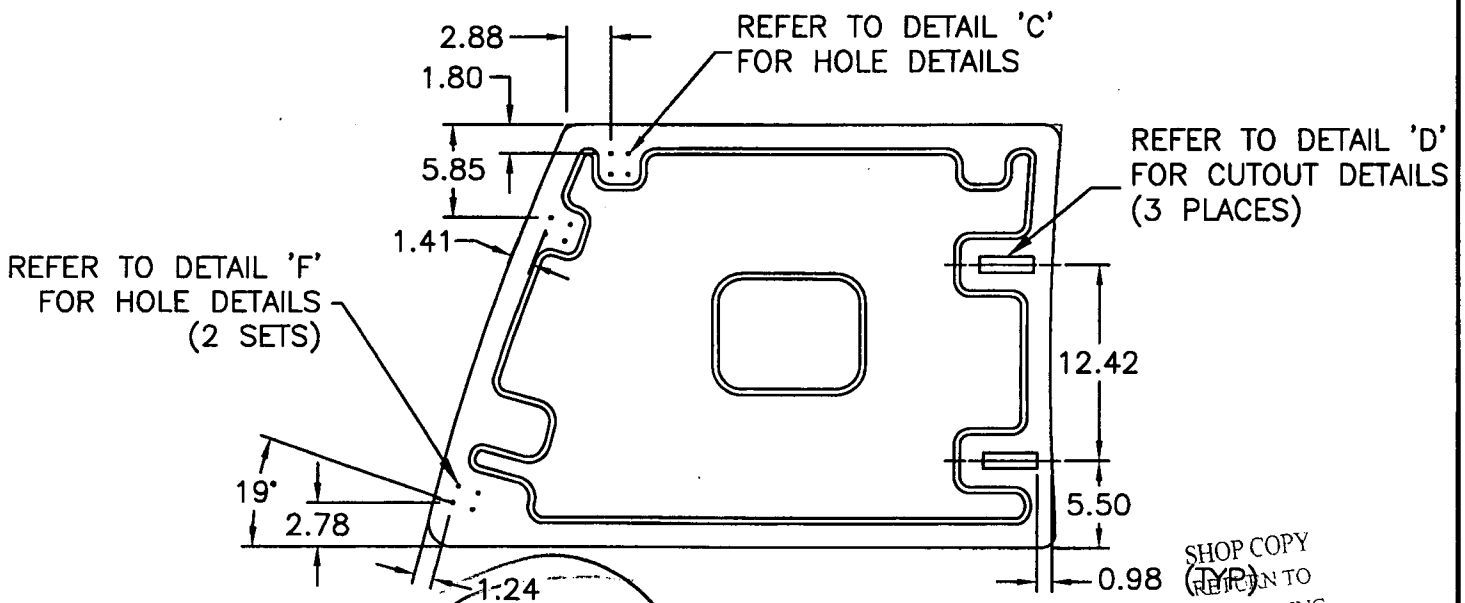
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DATE 07.02.22	TITLE SPACEPOD DOOR		SCALE NTS

**RELEASED**

07-02-27 H



**D3186-2 SPACEPOD DOOR. RH**  
**(MAKE FROM D3186-2M)**



**D3186-4 SPACEPOD DOOR. RH**  
**(MAKE FROM D3186-2M)**

**NOTES:**

- 1) ALL DIMENSIONS ARE IN INCHES
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

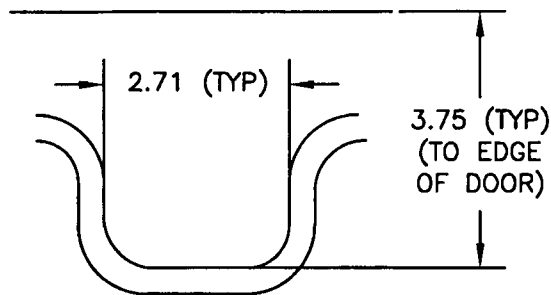
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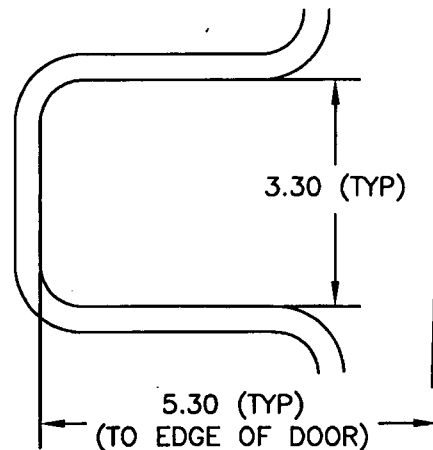
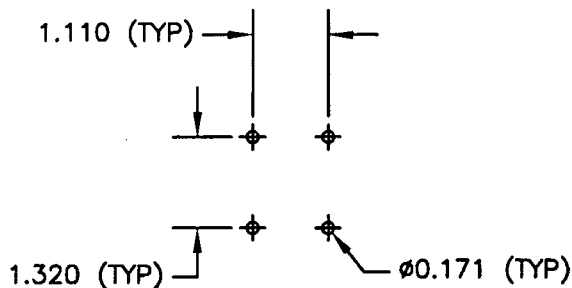
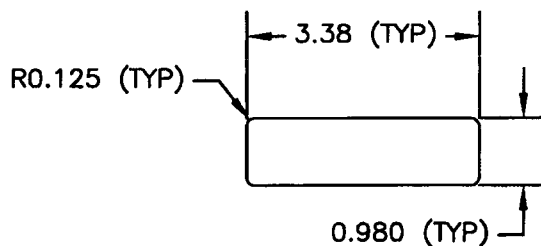
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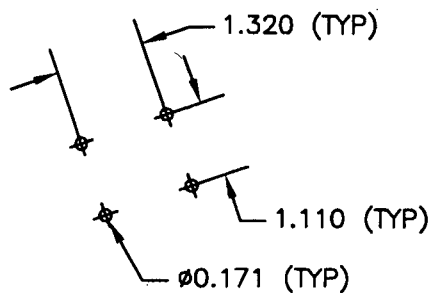
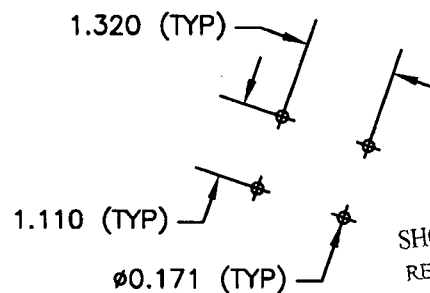
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DATE 07.02.22	TITLE SPACEPOD DOOR		SCALE NTS

**DETAIL A****RELEASED**

07.02.27 [Signature]

**DETAIL B****DETAIL C**

NOTE: ENSURE THAT CUTOUT IS PERPENDICULAR TO EDGE OF DOOR

**DETAIL D****DETAIL E****DETAIL F****NOTES:**

- 1) ALL DIMENSIONS ARE IN INCHES
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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Date: Wednesday, 12/20/2006 1:46:20 PM  
 User: Kim Johnston

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : SPACEPOD BODY RH
<b>Job Number</b> : 30044	
<b>Estimate Number</b> : 12596	
<b>P.O. Number</b> : N/A	<b>Part Number</b> : D31882M
<b>This Issue</b> : 12/20/2006 <b>S.O. No.</b> : N/A	<b>Drawing Number</b> : D3188 REV <i>BC</i> <i>UE</i> 07.01.18
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : N/A <b>Type</b> : PURCHASED PARTS	<b>Drawing Revision</b> : <i>BC</i> <i>UE</i> 07.01.18
<b>Previous Run</b> : 30043	<b>Material</b> : N/A
<b>Written By</b> : <i>[Signature]</i>	<b>Due Date</b> : 1/20/2007 <b>Qty:</b> 1 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <i>[Signature]</i> 061220	
<b>Comment</b> : Est Rev:A New issue ecn882 06-11-30 EC	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
----------------	------------------------------	----------------------

1.0	D2213	Aluminum Spacer
-----	-------	-----------------



**Comment:** Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)  
 Ship To Delastek

8 D2213 Spacer Batch: *B30049* *C20710102* *[Signature]*

2.0	PG	PURCHASING
-----	----	------------

**Comment:** PURCHASING

Issue P/O: *2762*  
 Description: D3188-2M BODY  
 SHIP: D2213 Spacers  
 Supplier: Delastek  
 Conformity Certificate and Process sheet required  
 Ship 2 Items from Previous steps

*C206112101* *[Signature]*

3.0	D31882P	Spacepod Body
-----	---------	---------------



**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
 Spacepod Body

4.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------

**Comment:** PACKAGING RESOURCE #1

Receive and inspect for transit damage. Ensure a copy of certification of conformity and process sheet from Delastek is attached.

*[Signature]* *C207104102*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/04/27

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 12/20/2006 1:46:20 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD BODY RH

Job Number: 30044

Part Number: D31882M

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

Inspect dimensions as per Dwg D3188 .Visual inspection. Check for void spot and pins.

*ml 07/04/12*

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

*ml 07/04/12*

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*07/04/12*

Job Completion



*U 07-04-27*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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JB	CE	HAWKESBURY, ONTARIO, CANADA	
CHECKED PH	APPROVED PH	DRAWING NO. D3188	SHEET 1 OF 11
DATE 06.12.13		TITLE SPACEPOD BODY	SCALE N/A
A	03.04.03	NEW ISSUE	
B	06.10.06	UPDATED DWG TO MATCH PRODUCT ADDED D3188-1M/-2M/-3M/-5/-6/-7	
C	06.12.13	REMOVED D0600-XXX LABELS	

**GENERAL NOTES:**

- REFERENCE DIMENSIONS MATCH AIRCRAFT CONTOUR AND DOOR OPENING
- LAMINATE PER DART QSI 006. LAMINATION SCHEDULE PER THIS DRAWING
- MATERIALS:

RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40

FIBER: 9.7 oz 7781 WEAVE "S" GLASS (9 oz SATIN)  
12 oz UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")  
18 oz ROVING "E" GLASS (18 oz CLOTH)  
OWENS CORNING MILLED FIBERS, "E" GLASS  
3M K20 GLASS BUBBLES

FOAM: A500 CORE CELL  
OR DIVINYCELL  
OR AIREX  
OR KLEGECELL  
FILL VOIDS IN FOAM WITH PASTE MADE FROM MILLED FIBERS & RESIN

- MOLD SHEDULE:

PART	LAYUP	TRIM AND DRILL
D3188-1M/-1/-5	DT8003	DT8501
D3188-2M/-2/-6	DT8004	DT8502
D3188-3M/-3/-7	DT8500	DT8501

- APPLY ANTI-SKID PAINT TO TOP SURFACE OF PODS PER QSI 005 4.4
- FINISH: INSIDE/OUTSIDE WITH GREY DUPONT HIGHBUILD PRIMER 1144-S
- ALL DIMENSIONS ARE IN INCHES
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

**RELEASED**  
06.12.22

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WORK ORDER

30044

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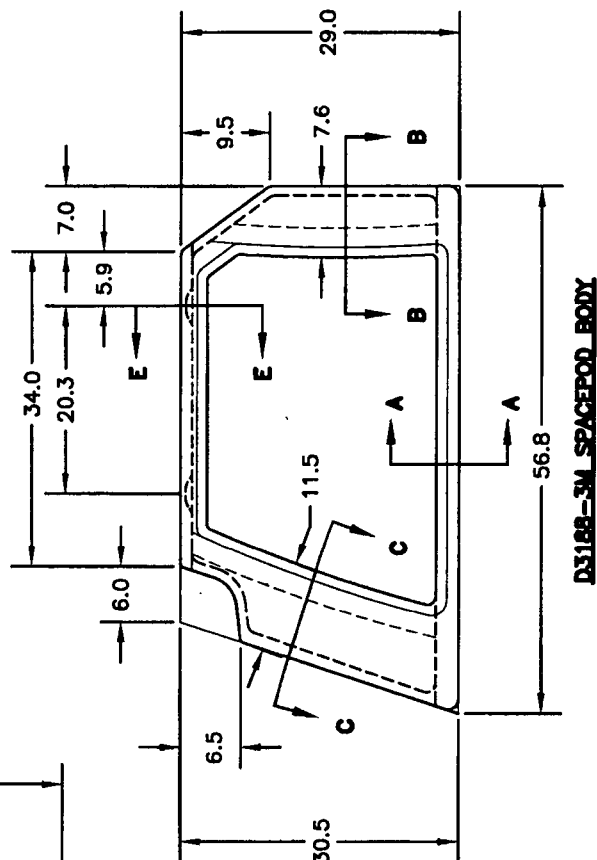
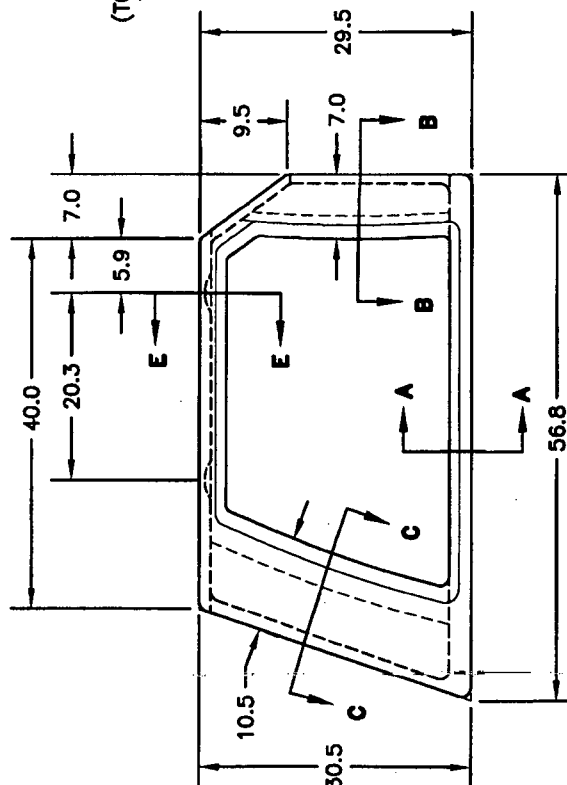
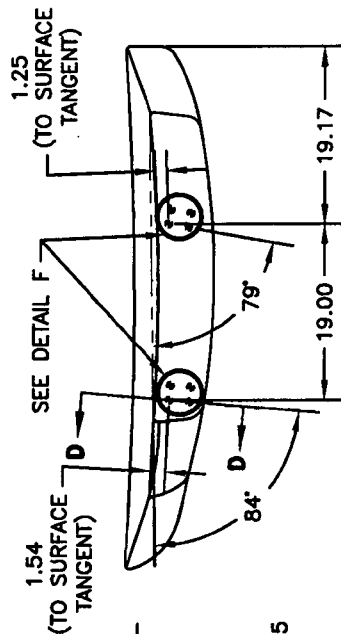
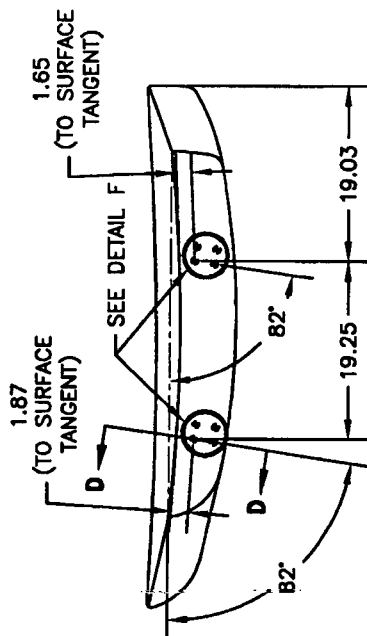
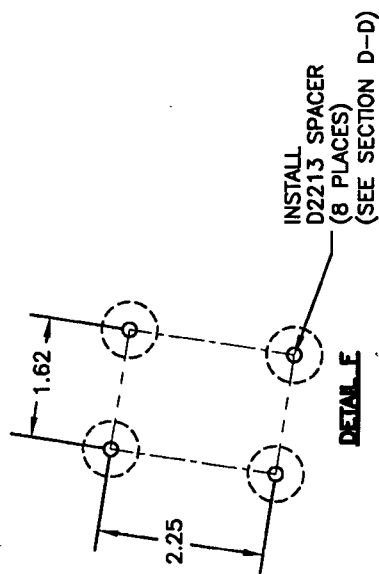
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DATE <b>06.12.13</b>	TITLE <b>SPACEPOD BODY</b>		SCALE NTS



D3188-1M SPACEPOD BODY

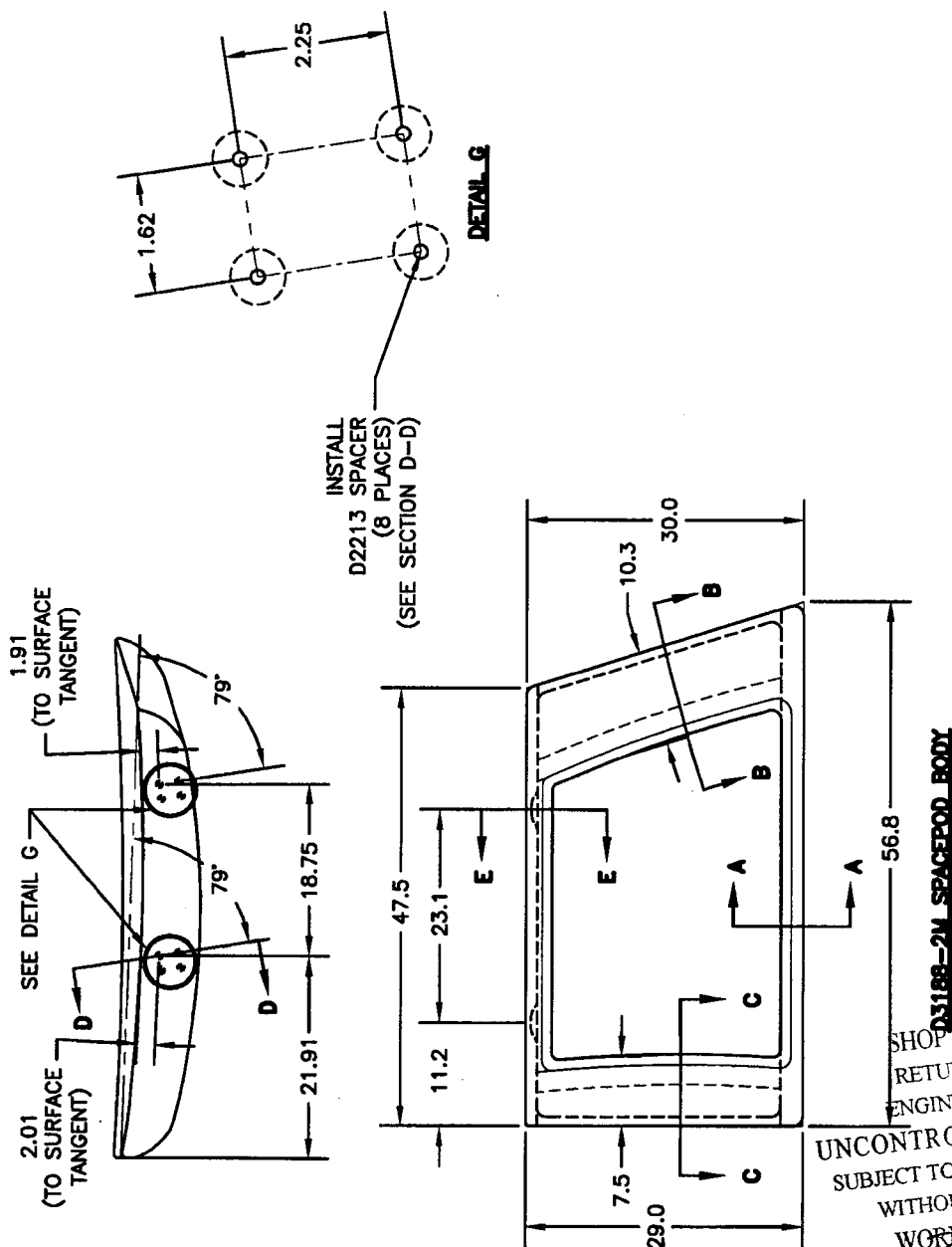
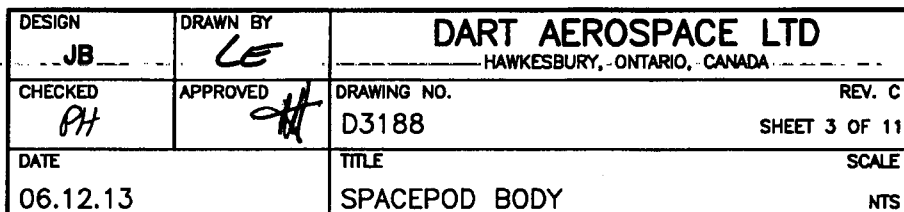
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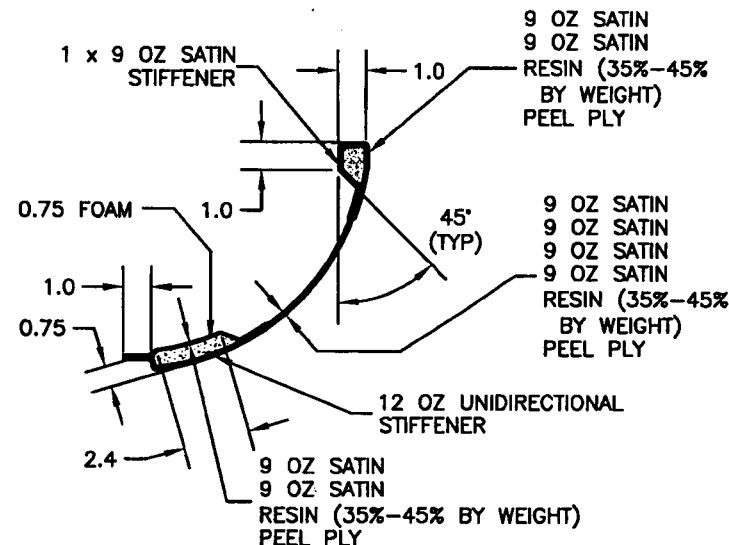
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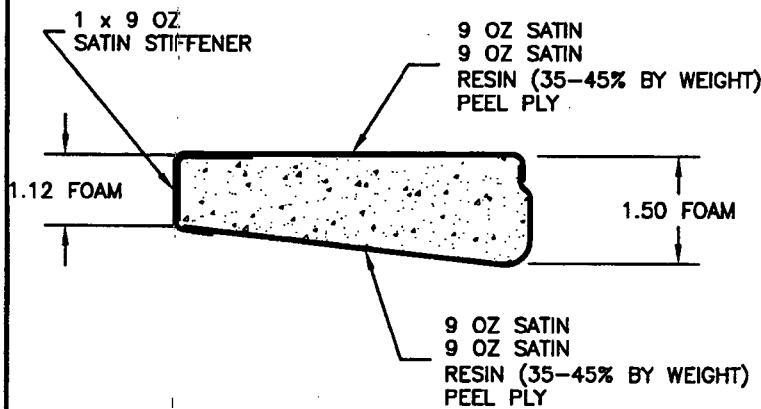
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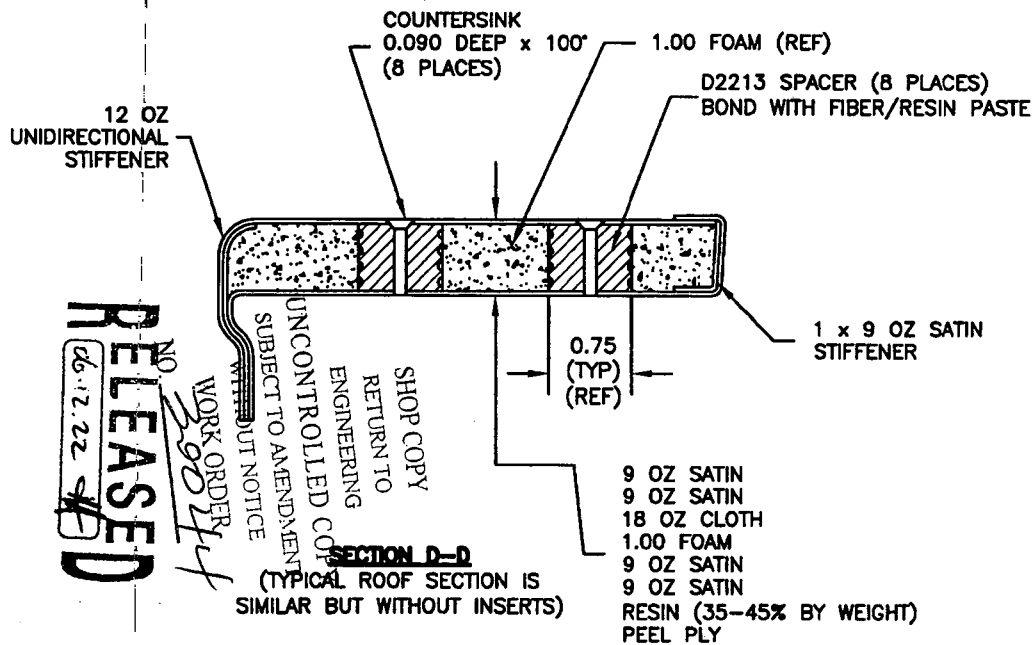
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		TITLE	SPACEPOD BODY	SHEET 4 OF 11	
		SCALE	NTS		



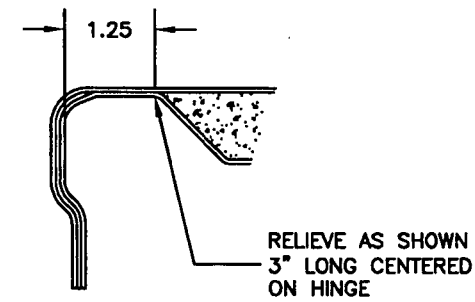
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(SECTION C-C OPPOSITE)



**SECTION A-A**  
(TYPICAL FLOOR SECTION)



**SECTION D-D**  
(TYPICAL ROOF SECTION IS  
SIMILAR BUT WITHOUT INSERTS)



**SECTION E-E**  
(2 PLACES PER POD)

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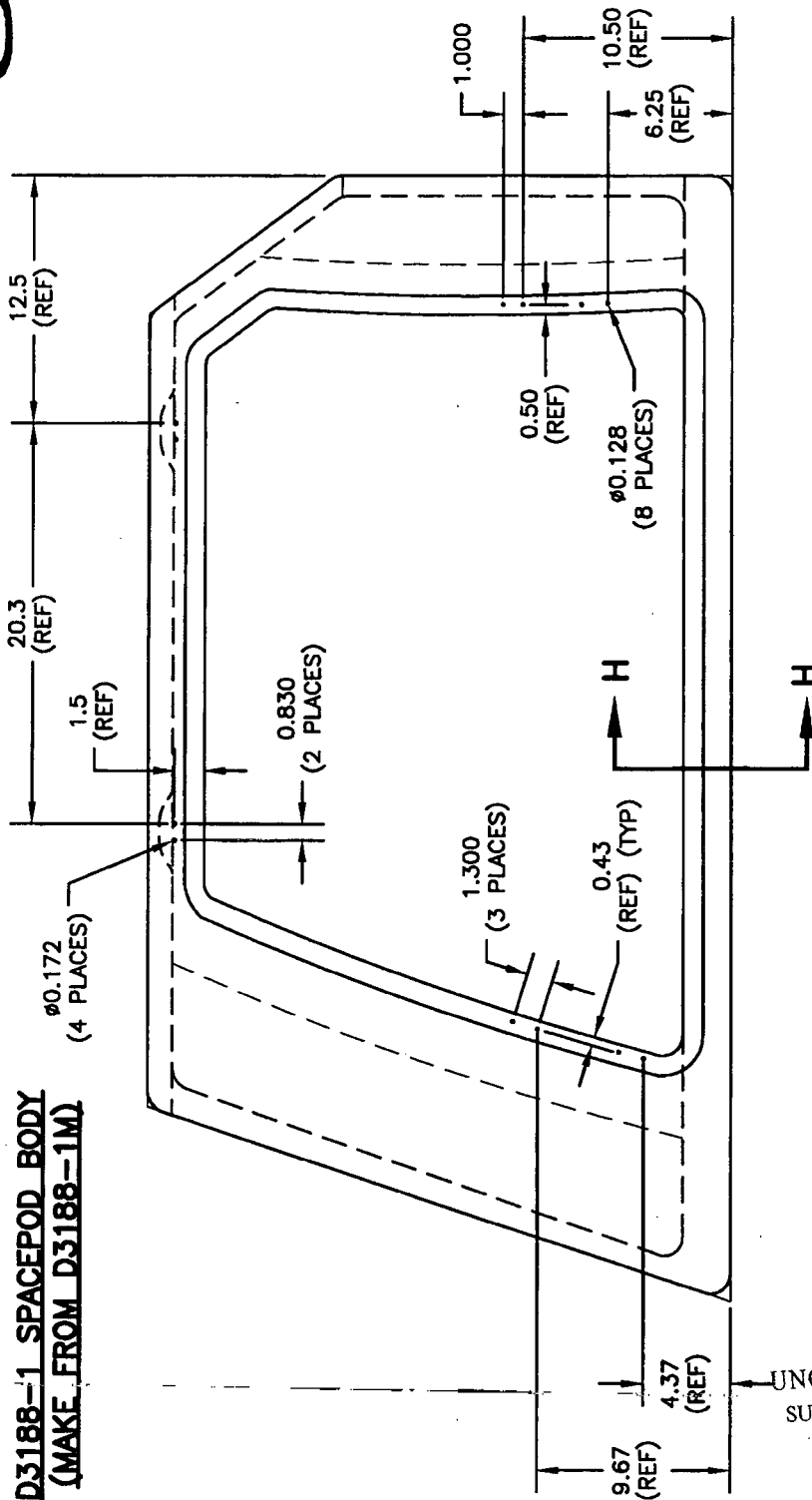
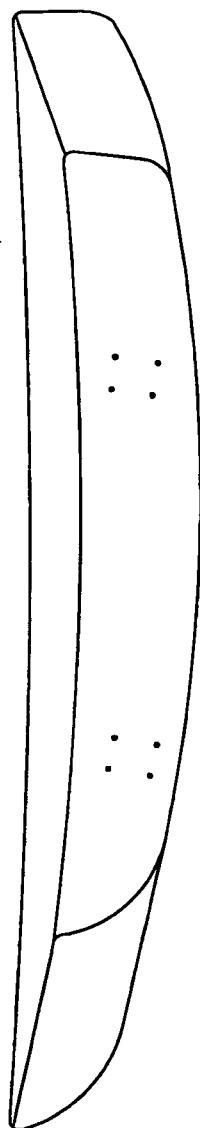
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DATE 06.12.13	TITLE SPACEPOD BODY		SCALE NTS

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06.12.22



D3188-1 SPACEPOD BODY  
(MAKE FROM D3188-1M)

- NOTES:
- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-1 DOOR DURING ASSEMBLY
  - 2) SEE SHEET #11 FOR SECTION VIEW

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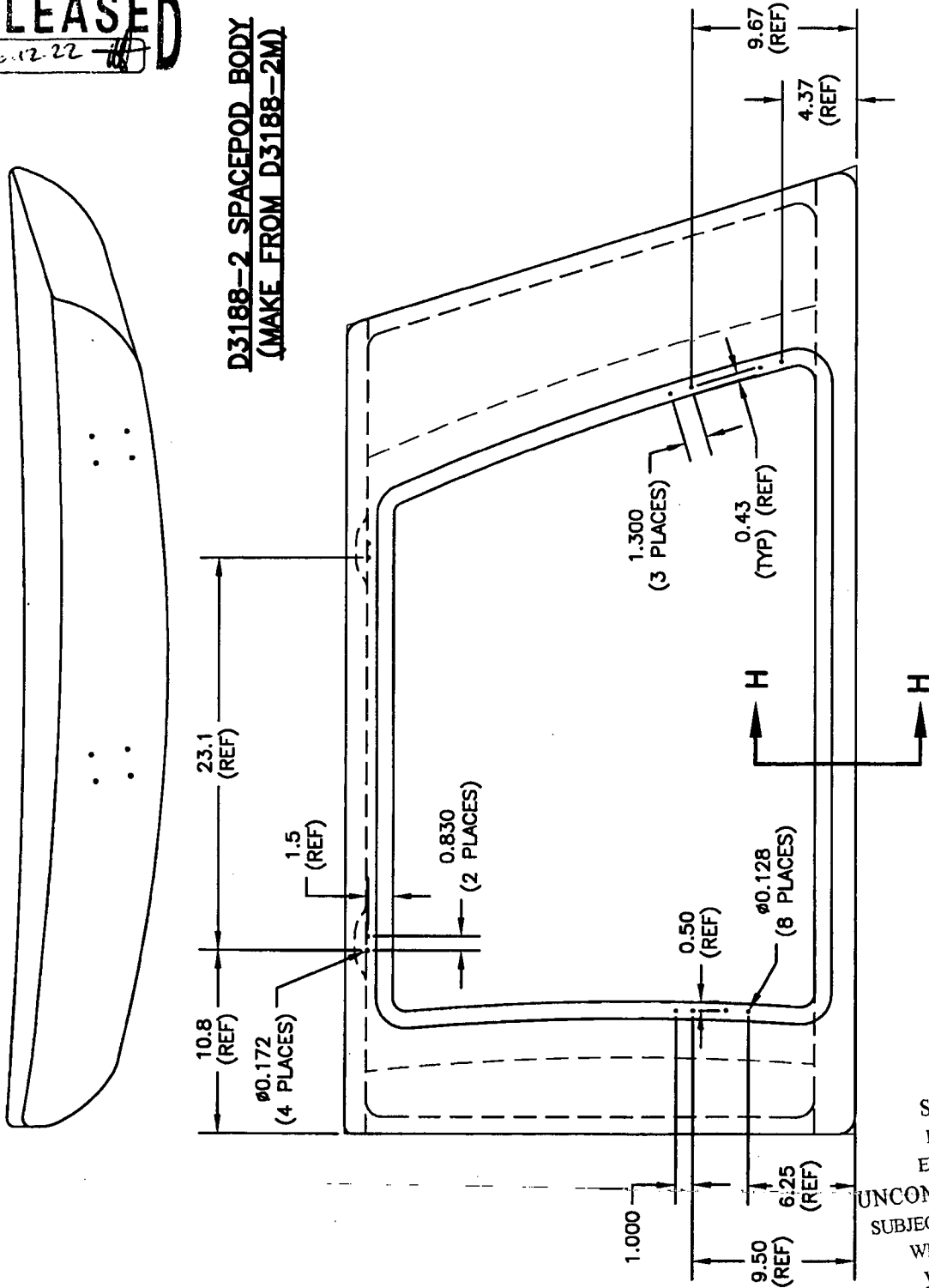
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DATE 06.12.13	TITLE SPACEPOD BODY		SCALE NTS

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a.12.22

**D3188-2 SPACEPOD BODY  
(MAKE FROM D3188-2M)**



**NOTES:**

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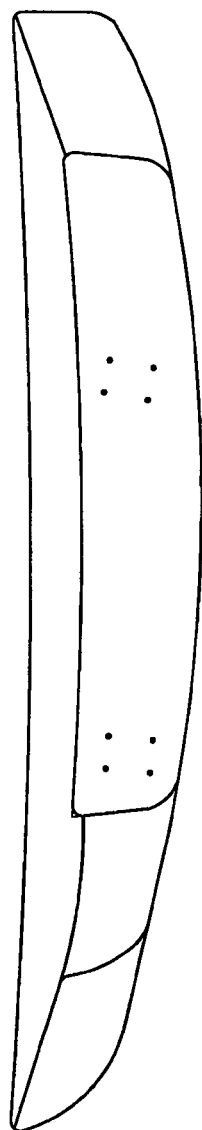
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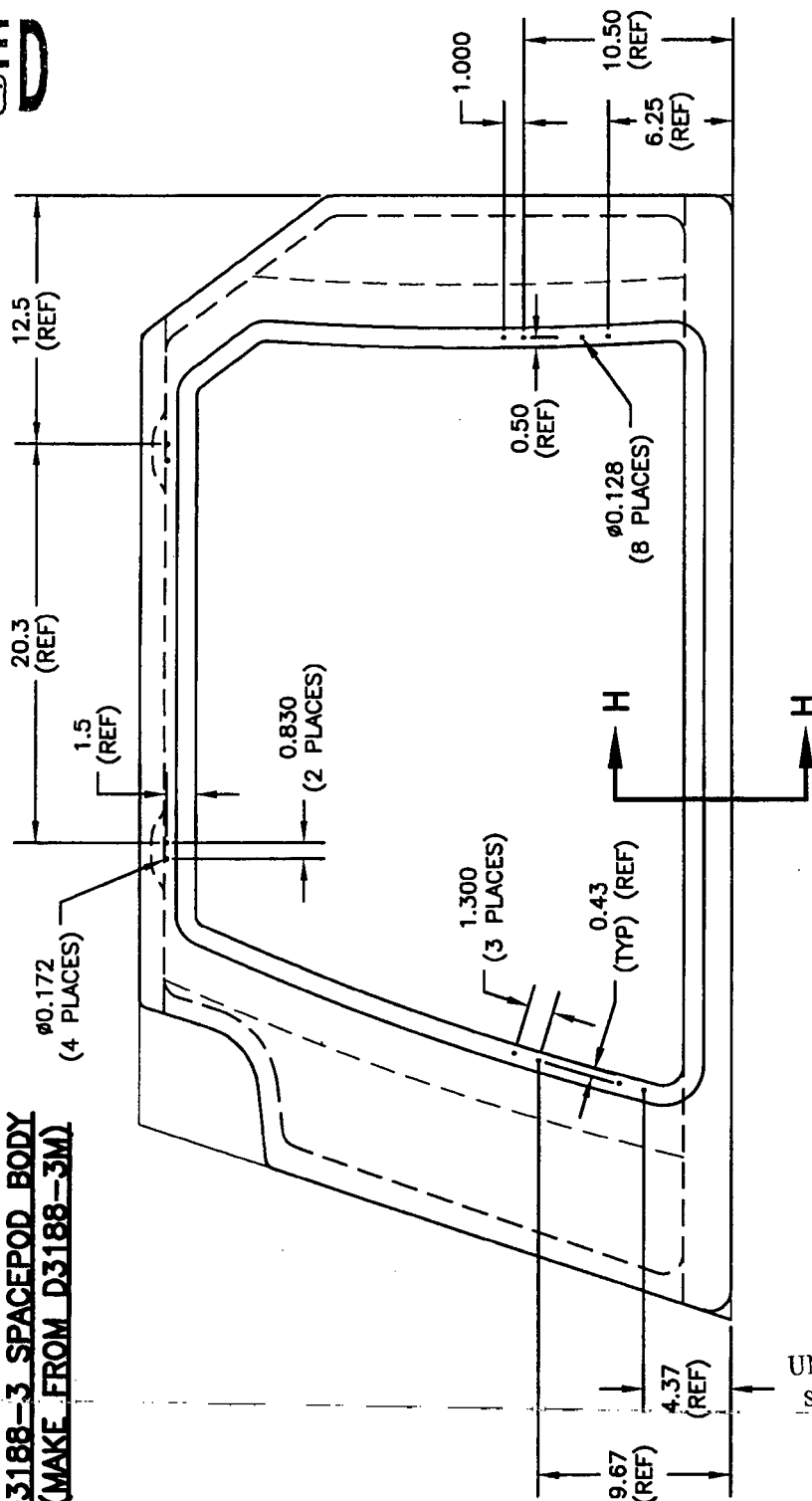


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**D3188-3 SPACEPOD BODY  
(MAKE FROM D3188-3M)**



**NOTES:**

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-1 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEW

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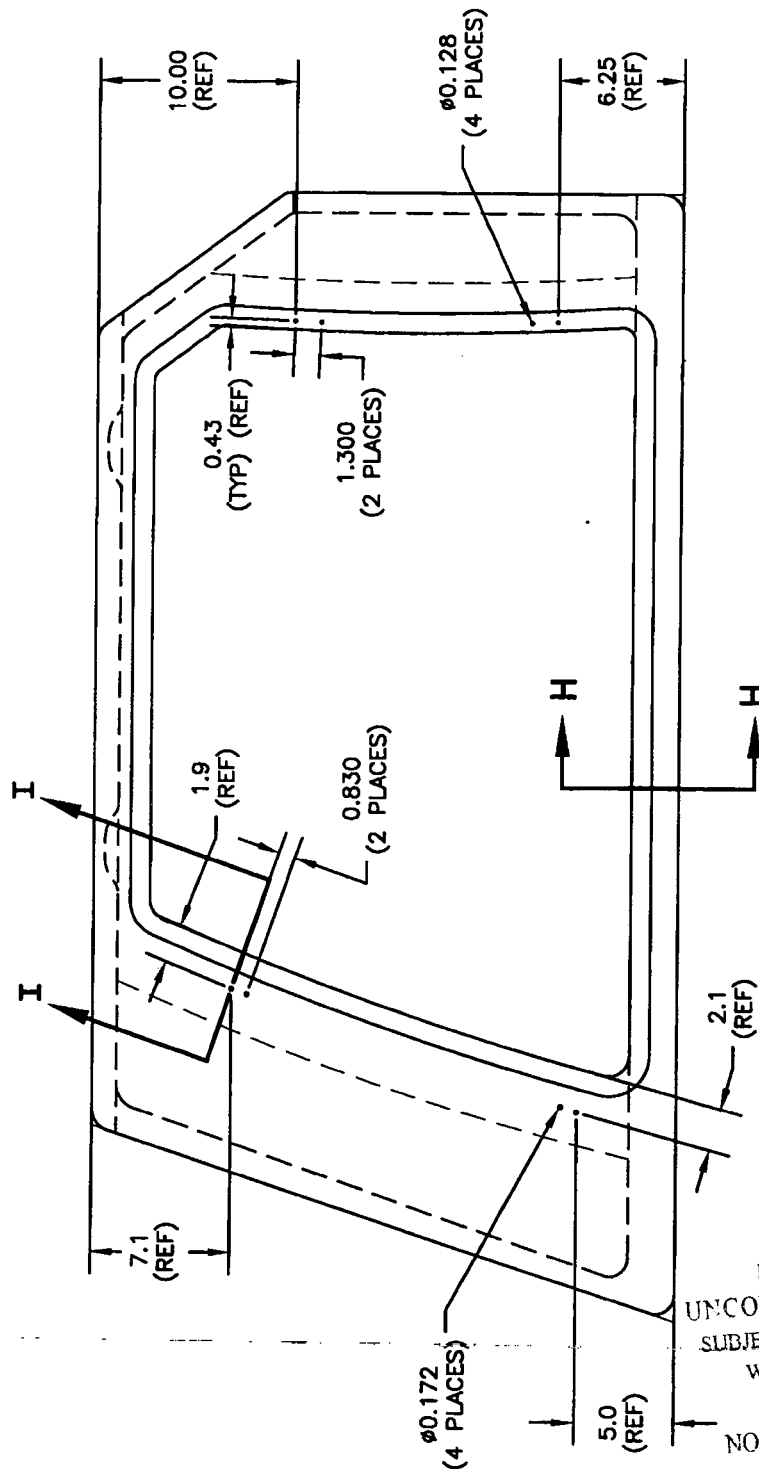
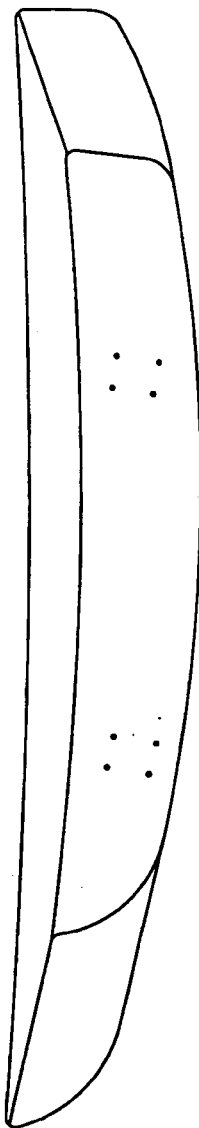
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DATE 06.12.13	TITLE SPACEPOD BODY		SCALE NTS

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06.12.22

D3188-5 SPACEPOD BODY  
(MAKE FROM D3188-1M)



NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-3 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEWS

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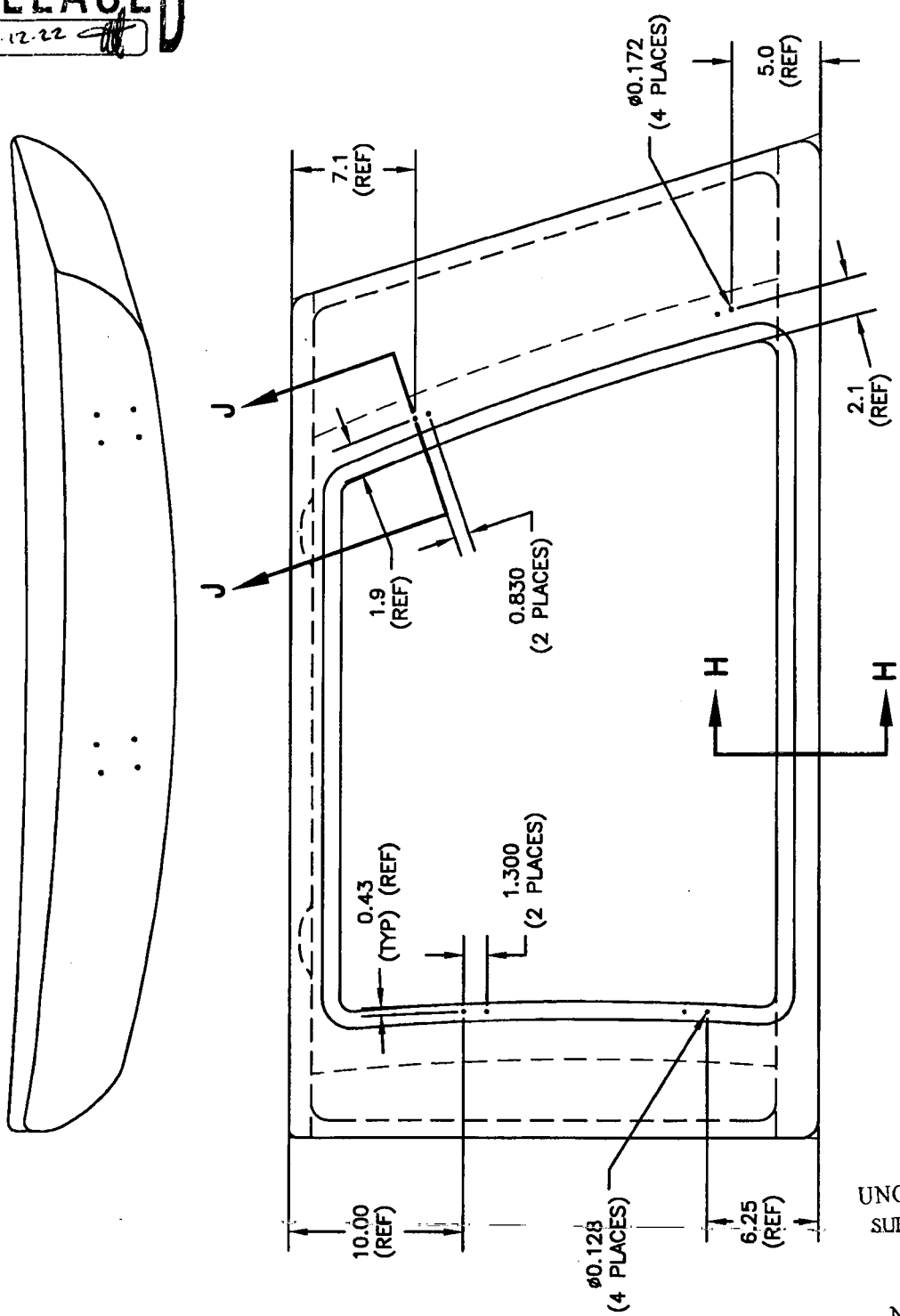
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DATE 06.12.13	TITLE SPACEPOD BODY		SCALE NTS

RELEASED  
06.12.22

D3188-6 SPACEPOD BODY  
(MAKE FROM D3188-2M)



NOTES:  
1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-4 DOOR DURING ASSEMBLY  
2) SEE SHEET #11 FOR SECTION VIEWS

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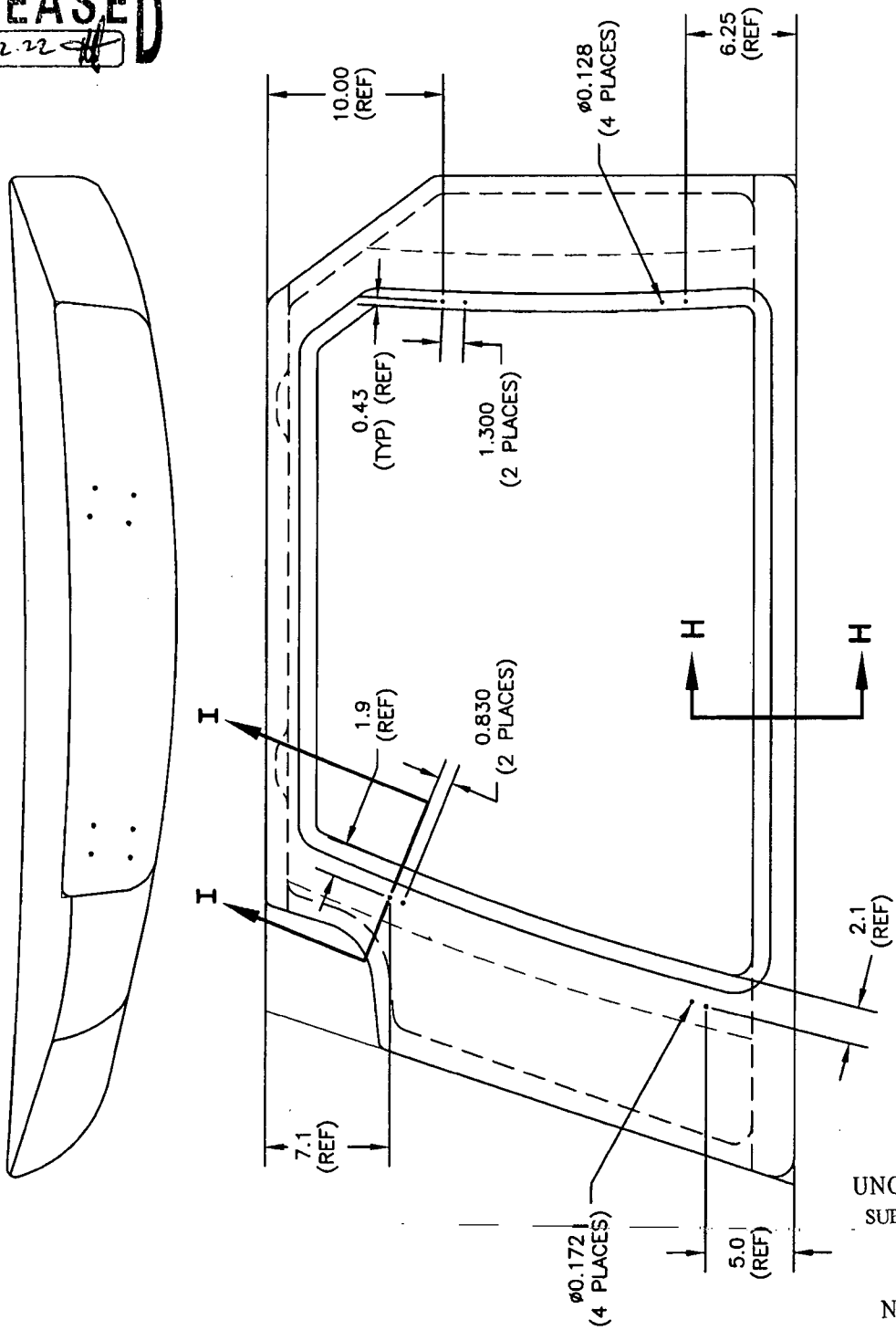
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CHECKED PH	APPROVED [Signature]	DRAWING NO. D3188	REV. C SHEET 10 OF 11
DATE 06.12.13		TITLE SPACEPOD BODY	SCALE NTS

RELEASED  
06.12.22

D3188-7 SPACEPOD BODY  
(MAKE FROM D3188-3M)



NOTE:  
1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE  
TRANSFER DRILLED FROM D3186-3 DOOR DURING ASSEMBLY  
2) SEE SHEET #11 FOR SECTION VIEWS

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DATE 06.12.13		TITLE SPACEPOD BODY	SCALE NTS

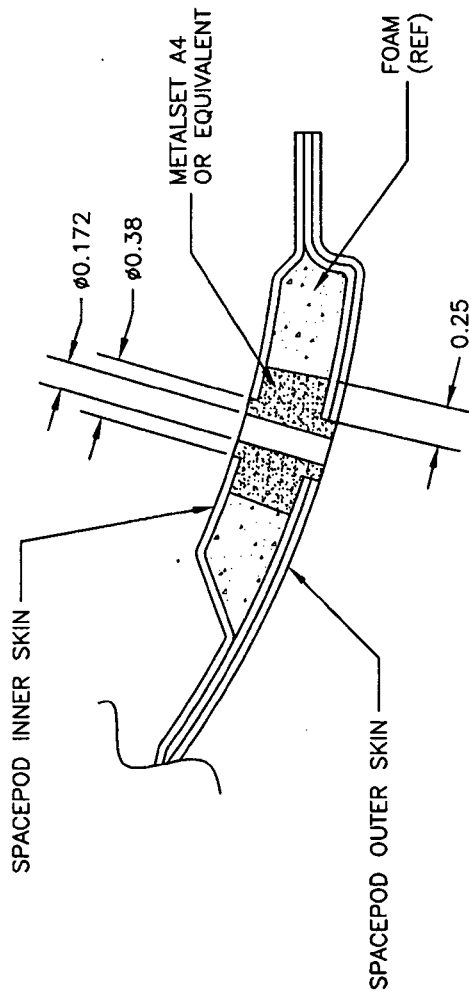
RELEASED  
6.12.22

INSTALL AKS7-1032-130  
INSERTS (29 PLACES)  
PER D3188-1T1 (D3188-1/-3/-5/-7)  
OR D3188-2T1 (D3188-2/-6)

FOAM  
(REF)



SECTION H-H  
(TYPICAL FLOOR SECTION)



SECTION I-I  
(SECTION J-J OPPOSITE)  
(4 PLACES PER POD)

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DELASTEK COMPOSITES INC.  
2699, 5ième Avenue  
Local 14, PORTE -A-  
Grand-Mère, Québec G9T 5K7  
Can \*\*Fax (819) 533-3494 \*\*

# PACKING SLIP CERTIFICATE OF COMPLIANCE

Invoice #	11809
Customer #	DART

Telephone: (819) 533-5788

Warehouse: MAIN

Bill to:

Dart Aerospace Ltd.  
1270, Aberdeen Street  
Hawkesbury, Ontario K6A 1K7  
Canada

Ship to:

Dart Aerospace Ltd.  
1270, Aberdeen Street  
Hawkesbury, Ontario K6A 1K7  
Canada

Telephone: 613-632-3336

Contact: Linda Lacelle

Ship via		F.O.B.		Terms		Salesperson	
EPIC EXPRESS COLLECT		Origin		Net30 days		Claude Lessard, ext. 233	
Ship date	Order Date	Our PO #	Order by		Your PO #	GST/PST #	
04/04/07	21/12/06	5092	C. Lavoie		PO00002767		
Order Qty	B.O. Qty	Current Ship	Item #	Item Description			
1	0	1	DKC134-0052	D3186-1M Spacepod Door LH B30014 Dwg. Rév.: C Job: 41247			
				U de M : Each			
1	0	1	DKC134-0053	D3188-1M Spacepod Body LH B30024 Dwg. Rév.: C Job: 41093			
				U de M : Each			
1	0	1	DKC134-0054	D3186-2M Spacepod Door RH B30034 Dwg. Rév.: C Job: 41249			
				U de M : Each			
1	0	1	DKC134-0055	D3188-2M Spacepod Body RH B30044 Dwg. Rév.: C Job: 41094			
				U de M : Each			

*[Handwritten signature]*

*ml 07/04/12*

It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request.

Accepted by:

Quality department

AQ-357

☒ Cust.

☐ Adm.

☐ Quality

☐ Ship.





Date: Mercredi, 2007-02-28 15:16:49  
 Auteur: Marc Dubé

## Feuille de Procédé

Client : DART	Dart Aerospace Ltd.	Nom Dessin : SPACEPOD BODY
Numéro Job : 41094		Numéro Article : DKC134-0055
Numéro Soumission : 2587		Numéro Dessin : D3188
Numéro B.A. :		Projet Numéro : DKC134
Étapes : 2007-02-28 No. B.V. :		Révision dessin : B
Statut Rev. : NC		Matériel : Fibre 7781 et Résine 411-350
Étapes : - -	Type :	Date Dûe : 2007-03-07
Étapes précédente : 41035		Qté: 1 Udm: UNITE

Émis par : \_\_\_\_\_  
 Vérifié & Approuvé par : \_\_\_\_\_  
 Commentaires : N° de pièce Dart Aerospace: D31882M  
 N° de Projet Delastek: DK-362


 Process Sheet Rev.: 00 Création du premier à partir du  
 DKC134-0020

Produit additionnel

Numéro Job:



# Séq.: Machine ou Opération: Description:

1.0 AC0303 Frekote 44NC

 Commentaire Qty.: 0.050 UNITE(s)/Unit Total: 0.050 UNITE(s)  
 Frekote 44NC

2.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART


 Commentaire Setup: 0.00Hr / Run: 5.0000Min Total Run: 0.0833Hrs  
 PRÉPARATION DU MOULE

 Faire la préparation du moule N° DT 8004 à l'aide de Frekote 44NC et laisser sécher pendant 3 heures selon  
 le QSI-006.

Date: 28/02/07 Heure Début: \_\_\_\_\_ Heure Fin: \_\_\_\_\_ Sceau: \_\_\_\_\_



3.0 AC0409 Tissu à délaminer Release ply B

 Commentaire Qty.: 9.84 VERGE(s)/Unit Total: 9.84 VERGE(s)  
 Tissu à délaminer Release ply B

4.0 AC0407 Wrightlon 5200 Bleu P3

 Commentaire Qty.: 9.27 VERGE(s)/Unit Total: 9.27 VERGE(s)  
 Wrightlon 5200 Bleu P3







5.0 AC0408 Feutre de drainage N° Airweave N 10

 Commentaire Qty.: 6.00 VERGE(s)/Unit Total: 6.00 VERGE(s)  
 Feutre de drainage N° Airweave N 10

6.0 AC0752 Stretchlon 200 poche à vide Vert

 Commentaire Qty.: 7.00 VERGE(s)/Unit Total: 7.00 VERGE(s)  
 Stretchlon 200 poche à vide Vert

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.		Nom Dessin: SPACEPOD BODY	
Numéro Job: 41094		Numéro Article: DKC134-0055	
Numéro Job:			
# Séq.:	Machine ou Opération:	Description :	
7.0	AAC032E	9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish	
Commentaire Qty.: 11.4 VERGE(s)/Unit Total: 11.4 VERGE(s) 9.7 oz: 7781 Weave "S" glass #FG-778150-125Y N° de Lot: <u>1-5905-1</u>			
8.0	AAC044E	Fiberglass 12 oz Unidirectional	
Commentaire Qty.: 0.80 VERGE(s)/Unit Total: 0.80 VERGE(s) Fiberglass 12 oz Unidirectional N° de Lot: <u>5455</u>			
9.0	AAC063E	WR1850 ROVING 18 OZ x 50"	
Commentaire Qty.: 0.35 VERGE(s)/Unit Total: 0.35 VERGE(s) WR1850 ROVING 18 OZ x 50" N° de Lot: <u>1-5873-1</u>			
10.0	AC0098	Ruban à gommer jaune #: T/AT-200Y	
Commentaire Qty.: 4.0000 RL(s)/Unit Total: 4.0000 RL(s) Ruban à gommer jaune #: T/AT-200Y			
11.0	PRÉPARATION 3	PRÉPARATION DU MATÉRIEL DART	
			
Commentaire Setup: 0.00Hr / Run: 45.0000Min Total Run: 0.7500Hrs TAILLAGE DU MATÉRIEL  Tailler le matériel, selon les différents patrons de découpe et les quantités inscrites sur ceux-ci.  À fin d'accélérer le processus de taillage, tailler les plis de 9.7 oz tous en même temps en les superposants les uns sur les autres.  Date: <u>27/02/07</u> Heure Début: _____ Heure Fin: _____ Sceau: 			
12.0	AAC0275	Catalyst N° DDM-9	
Commentaire Qty.: 0.0640 PINTE(s)/Unit Total: 0.0640 PINTE(s) Catalyst N° DDM-9 N° de Lot: <u>5921</u>			
13.0	AAC034E	Résine (411B7530) 411-350 promo. 75min.	
Commentaire Qty.: 2.000 KILOGRAMME(s)/Unit Total: 2.000 KILOGRAMME(s) Résine (411E 7530) 411-350 promo. 75min. N° de Lot: <u>1-6015-1</u>			
14.0	AAC0673	Fibre de verre Miapoxy 66	
Commentaire Qty.: 0.0039 GALLON(s)/Unit Total: 0.0039 GALLON(s) Fibre de verre Miapoxy 66  N° de Lot: <u>1-5502-1</u>			
15.0	PRÉPARATION 3	PRÉPARATION DU MATÉRIEL DART	
			
Commentaire Setup: 0.00Hrs / Run: 5.0000Min Total Run: 0.0833Hrs PRÉPARATION DU MATÉRIEL  Faire la préparation de la résine selon les quantités requises, mix ration 2% de Catalyst N° DDM-9 par quantité de résine N° 411-350.			

## Feuille de Procédé

Client: DART Dart Aer space Ltd.

Nom Dessin: SPACEPOD BODY

Numéro Job: 41094

Numéro Article: DKC134-0055

Numéro Job:



# Séq.: Machine ou Opération:

Description:

Préparer une seringue de 30 ml de résine chargée de fibre de verre miapoxy 66

Date: 18/02/07 Heure Début: \_\_\_\_\_ Heure Fin: \_\_\_\_\_ Sceau:

16.0

LAMINAGE.

LAMINAGE PIÈCE DART



Commentaire Setup: 0.00Hrs / Run: 90.0000Min Total Run: 1.5000Hrs

FAIRE LE LAMINAGE DES TISSUS

À l'aide de la seringue, faire un joint tout le tour de la dénivellation pour la porte directement dans le moule.

À l'aide d'un rouleau 2" dia. appliquer une couche de résine N° 411-350 sur le moule N° DT 8004 et ensuite imbiber un pli le tissu 9.7oz. et 18 oz. sur la section supérieur de la pièce.

Laminage du 2 oz.

Recommence l'opération pour le deuxième pli.

Date: 18/02/07 Heure Début: \_\_\_\_\_ Heure Fin: \_\_\_\_\_ Sceau:

17.0

POCHE À VIDE 1

FAIRE LA POCHE À VIDE



Commentaire Setup: 0.00Hrs / Run: 20.0000Min Total Run: 0.3333Hrs

EFFECTUER LA POCHE A VIDE

Faire la poche à vide en appliquant les composantes dans l'ordre suivant:

- 1- Tissu à déliminer,
- 2- Film perforé P-3,
- 3- Feutre de drainage
- 4- Sac à vide Stretchlon 200

Laisser sécher pendant 4 heures minimum.

Date: 18/02/07 Heure Début: \_\_\_\_\_ Heure Fin: \_\_\_\_\_ Sceau:

Curing Début: \_\_\_\_\_ Curing Fin: \_\_\_\_\_

18.0

AAC0457

ATC core-cell A500 plain 4'x8' 1" thick













Commentaire Qty: 0.75 FEUILLE(s)/Unit Total: 0.75 FEUILLE(s)

ATC core-cell A500 plain 4'x8' 1" thick Selon dessin D3188 de Dart

N° de Lot:

3-5915-2












## Feuille de Procédé

Client: DART Dart Aerospace Ltd.		Nom Dessin: SPACEPOD BODY	
Numéro Job: 41094		Numéro Article: DKC134-0055	
Numéro Job:			
# Séq.:	Machine ou Opération:	Description :	
19.0	FAB GÉNÉRALE 3	FABRICATION GÉNÉRALE DART	
			
<p>Commentaire Setup: 0.00Hr / Run: 120.0000Min Total Run : 2.0000Hrs  TAILLAGE DU MATÉRIEL</p> <p>Tailler le Foam Core 1" selon le plan de découpe et les gabarits</p> <p>Date: <u>5/03/07</u> Heure Début: _____ Heure Fin: _____ Sceau: </p>			
20.0	AAC0324	Résine (411B7530) 411-350 promo. 75min.	
<p>Commentaire Qty.: 0.200 KILOGRAMME(s)/Unit Total: 0.200 KILOGRAMME(s)  Résine (411B 7530) 411-350 promo. 75min.</p> <p>N° de Lot: <u>1-6015-1</u></p>			
21.0	AAC0275	Catalyst N° DOM-9	
<p>Commentaire Qty.: 0.0064 PINTE(s)/Unit Total: 0.0064 PINTE(s)  Catalyst N° DOM-9</p> <p>N° de Lot: <u>5921</u></p>			
22.0	FINITION 3	FINITION PIÈCE DART	
			
<p>Commentaire Setup: 0.00H s/ Run: 0.0000Min Total Run : 0.0000Hrs  FINITION PIÈCE DART</p> <p><u>5/03/07</u>  </p> <p>Prendre les deux pièces de 11" x 57" et sceller la grande surface sur chacune d'elle selon I.G. # Sceller le Foam Core.</p>			
23.0	AAC0452	Polybond B46F	
<p>Commentaire Qty.: 0.010 KIT(s)/Unit Total: 0.010 KIT(s)  Polybond B46F</p> <p>N° de Lot: <u>1-5865-1</u></p>			
24.0	FINITION 3	FINITION PIÈCE DART	
			
<p>Commentaire Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs  FINITION PIÈCE DART</p> <p>À l'aide du Polybond, coller ensemble les deux surfaces scellées</p> <p>Disposer de poids sur les pièces pour conserver une pression de collage.</p> <p>Laisser sécher pour un minimum de deux heures.</p> <p>Quantité: <u>1</u> Date: <u>6/03/07</u> Sceau:  </p>			












ite: Mercredi, 2007-02-28 15:16:49

Utilisateur: Marc Dubé

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.		Nom Dessin: SPACEPOD BODY	
Numéro Job: 41094		Numéro Article: DKC134-0055	
Numéro Job:			
# Séq.:	Machine ou Opération:	Description:	
<p>Quantité: _____ Date: _____ Sceau: _____</p>			
25.0	TRIMAGE 3	TRIMAGE COMPOSITES DART	
			
<p>Commentaire Setup: 0.00Hr / Run: 0.0000Min Total Run : 0.0000Hrs TRIMAGE COMPOSITES DART</p> <p>Ajuster chacune des pièces de foam core dans le moule selon le dessin.</p> <p>Quantité: _____ Date: <u>7/03/07</u> Sceau: </p> <p>Quantité: _____ Date: _____ Sceau: _____</p>			
26.0	AAC0324	Résine (411B7530) 411-350 promo. 75min.	
<p>Commentaire Qty.: 0.300 KILOGRAMME(s)/Unit Total : 0.300 KILOGRAMME(s) Résine (411B 530) 411-350 promo. 75min.</p> <p>N° de Lot: <u>1-6015-1</u></p>			
27.0	AAC0275	Catalyst N° DDM-9	
<p>Commentaire Qty.: 0.0096 PINTE(s)/Unit Total : 0.0096 PINTE(s) Catalyst N° DDM-9</p> <p>N° de Lot: <u>5921</u></p>			
28.0	PRÉPARATION 3	PRÉPARATION DU MATÉRIEL DART	
			
<p>Commentaire Setup: 0.00Hrs / Run: 10.0000Hrs Total Run : 10.0000Hrs PRÉPARATION DU MATÉRIEL DART</p> <p style="text-align: right;"><u>8/03/07</u> </p> <p>Faire la préparation de la résine selon les quantités requises, mix ratio 2% de Catalyst N° DDM-9 par quantité de résine N° 411-350 promu 75 minutes..</p>			
29.0	FAB GÉNÉRALE	FABRICATION GÉNÉRALE DART	
			
<p>Commentaire Setup: 0.00Hrs / Run: 20.0000Hrs Total Run : 20.0000Hrs FABRICATION GÉNÉRALE PLASTIC COMMERCIAL</p> <p>Retirer les pièces de foam core du moule</p> <p>Sceller les foam core à l'aide de la résine promu N° 411-350 75 minutes. Selon I.G.# Sceller le foam Core.</p> <p>Laisser sécher pendant 2 heures minimum</p> <p>Date: <u>8/03/07</u> Sceau:   Initiales: _____</p>			

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.		Nom Dessin: SPACEPOD BODY	
Numéro Job: 41094		Numéro Article: DKC134-0055	
Numéro Job:			
# Séq.:	Machine ou Opération:	Description :	
30.0	AAC0452	Polybond B46F	
Commentaire Qty.: 0.078 KIT(s)/Unit Total : 0.078 KIT(s) Polybond B46 N° de Lot: 1-5865-1			
31.0	PRÉPARATION 3	PRÉPARATION DU MATÉRIEL DART	
			
Commentaire Setup: 0.00Hr / Run: 5.0000Min Total Run : 0.0833Hrs PRÉPARATION DU MATÉRIEL			
Faire la préparation du Poly bond. Date: 9/6/07 Heure Début: _____ Heure Fin: _____ Sceau: 			
32.0	ASSEMBLAGE 3	ASSEMBLAGE GÉNÉRALE DART	
			
Commentaire Setup: 0.00Hr / Run: 60.0000Min Total Run : 1.0000Hrs ASSEMBLAGE GÉNÉRALE DES PIÈCES			
Coller les différents pièces de Foam Core dans les Spacepod Body à l'aide du Poly bond. Date: 9/6/07 Heure Début: _____ Heure Fin: _____ Sceau:   			
33.0	POCHE À VIDE 1	FAIRE LA POCHE À VIDE	
			
Commentaire Setup: 0.00Hr / Run: 20.0000Min Total Run : 0.3333Hrs EFFECTUER LA POCHE A VIDE			
Faire la poche à vide en appliquant les composantes dans l'ordre suivant:			
1- Tissu à déaminer, 2- Film perforé P-3, 3- Fautre de drainage 4- Sac à vide Stretchlon 200			
Laisser sécher pendant 2 heures minimum.			
Retirer le bagging entre 1 heure et 1 heure 1/2 après le mélange de la résine afin d'enlever le surplus de polybond avant que celui-ci ne soit complètement polymérisé.			
Date: 9/6/07 Heure Début: _____ Heure Fin: _____ Sceau:   			
Curing Début: _____ Curing Fin: _____			

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: SPACEPOD BODY

Numéro Job: 41094

Numéro Article: DKC134-0055

Numéro Job:



# Séq.: Machinerie ou Opération: Description:

34.0 AC0058

Polysoft 1.3 kg # 003012 Sikkens

Commentaire Qty.: 0.100 UNITE(s)/Unit Total: 0.100 UNITE(s)

Polysoft 1.3 kg # 003012 Sikkens

N° de Lot:

1-5957-1

35.0 AC0058

Durcisseur Polysoft #004009 Sikkens

Commentaire Qty.: 0.078 UNITE(s)/Unit Total: 0.078 UNITE(s)

Durcisseur Polysoft #004009 Sikkens

36.0 FINITION 3

FINITION PIÈCE DART



Commentaire Setup: 0.00Hrs/ Run: 30.0000Min Total Run: 0.5000Hrs

FINITION GÉNÉRALE

Corriger les petits défauts de surface de la pièce avec du Sikkens. Pour les plus gros défauts utiliser du polycond

Date:

12/02/07

Heure Début:

Heure Fin:

Sceau:



37.0 TRIMAGE 3

TRIMAGE COMPOSITES DART



Commentaire Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs

TRIMAGE COMPOSITES DART

Tailler le foam core afin d'ajuster le contour de la pièce à celui du moule

12/03/07



38.0 AAC0324

Résine (411B7530) 411-350 promo. 75min.

Commentaire Qty.: 0.100 KILOGRAMME(s)/Unit Total: 0.100 KILOGRAMME(s)

Résine (411B7530) 411-350 promo. 75min.

N° de Lot:

1-6032-1

39.0 AAC0275

Catalyst N° DDM-9

Commentaire Qty.: 0.0032 PINTE(s)/Unit Total: 0.0032 PINTE(s)

Catalyst N° DDM-9

N° de Lot:

5921

40.0 FINITION 3

FINITION PIÈCE DART



Commentaire Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs

FINITION PIÈCE DART












Sceller le foam core qui a été exposé suite au taillage précédent selon I.G. # Sceller le Foam Core

Laisser sécher pendant minimum deux heures.

13/03/07



## Feuille de Procédé

Client: DART	Dart Aerospace Ltd.	Nom Dessin: SPACEPOD BODY	
Numéro Job: 41094		Numéro Article: DKC134-0055	
Numéro Job:			
# Séq.:	Machine ou Opération:	Description :	
41.0	AAC0275	Catalyst N° DDM-9	
Commentair Qty.: 0.050 PINTE(s)/Unit Total: 0.0504 PINTE(s) Catalyst N° DDM-9 N° de Lot: <u>5921</u>			
42.0	AAC0321	Résine (411B7530) 411-350 promo. 75min.	
Commentair Qty.: 1.500 KILOGRAMME(s)/Unit Total: 1.500 KILOGRAMME(s) Résine (411B 530) 411-350 promo. 75min. N° de Lot: <u>1.6032-1</u>			
43.0	PRÉPARATION 3	PRÉPARATION DU MATÉRIEL DART	
 			
Commentair Setup: 0.00Hr / Run: 5.0000Min Total Run : 0.0833Hrs PRÉPARATION DU MATÉRIEL  Faire la préparation de la résine selon les quantités requises, mix ratio 2% de Catalyst N° DDM-9 par quantité de résine N° 411-350. Date: <u>15/03/07</u> Heure Début: _____ Heure Fin: _____ Sceau: 			
44.0	INSPECTION 3	INSPECTION PIÈCE DART	
 			
Commentair Setup: 0.00Hrs / Run: 90.0000Min Total Run : 1.5000Hrs FAIRE LE LAMINAGE DES TISSUS  Laminer deux pli de 9.7 oz 7781 S-Glass partout dans le moule. Le laminage doit être fait à l'aide de la résine N° 411-350 / 2% DDM-9. Date: <u>15/03/07</u> Heure Début: _____ Heure Fin: _____ Sceau:   			
45.0	POCHE À VIDE 1	FAIRE LA POCHE À VIDE	
 			
Commentair Setup: 0.00Hrs / Run: 20.0000Min Total Run : 0.3333Hrs EFFECTUER LA POCHE A VIDE  Faire la poche à vide en appliquant les composantes dans l'ordre suivant:  1- Tissu à déaminer, 2- Film perforé P-3, 3- Feutre de drainage 4- Sac à vide Stretchlon 200  Laisser sécher pendant 4 heures minimum.			



Date: Mercredi, 20/07-02-28 15:16:50

Utilisateur: Marc Dubé

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: SPACEPOD BODY

Numéro Job: 41094

Numéro Article: DKC134-0055

Numéro Job:



# Séq.: Machine ou Opération:

Description:

Date: 15/03/07 Heure Début: \_\_\_\_\_ Heure Fin: \_\_\_\_\_ Sceau:



Curing Début: \_\_\_\_\_ Curing Fin: \_\_\_\_\_

46.0 DÉMOULAGE 1

DÉMOULAGE PIÈCE DART



Commentaire Setup: 0.00H s/ Run: 30.0000Min Total Run: 0.5000Hrs

DÉMOULAGE : DES PIÈCES

Démouler la pièce en se servant de la prise d'air sous le moule en faisant bien attention de ne pas abîmer les différentes surfaces de la pièce.

Date: 16/03/07 Heure Début: \_\_\_\_\_ Heure Fin: \_\_\_\_\_ Sceau:



47.0 TRIMAGE 3

TRIMAGE COMPOSITES DART



Commentaire Setup: 0.00H s/ Run: 60.0000Min Total Run: 1.0000Hrs

TRIMAGE D : FINITION

Perçer les 8 trous sur la section supérieure de la pièce ainsi que l'ouverture pour la porte à l'aide du gabarit N° DT:802.

Par l'intérieur, perçer les 8 dégagement de ø .745" pour les spacers N° D2213 ( ne pas percer la peau extérieure de la pièce )

Date: 19/03/07 Heure Début: \_\_\_\_\_ Heure Fin: \_\_\_\_\_ Sceau:



48.0 AAC0:75

Catalyst N° DDM-9

Commentaire Qty.: 0.048 PINTE(s)/Unit Total: 0.0048 PINTE(s)

Catalyst N° DDM-9

N° de Lot: 5921

49.0 AAC0324

Résine (41187530) 411-350 promo. 75min.

Commentaire Qty.: 0.10 KILOGRAMME(s)/Unit Total: 0.150 KILOGRAMME(s)

Résine (41137530) 411-350 promo. 75min.

N° de Lot: 1-6032-1

50.0 AAC0573

Fibre de verre Miapoxy 66

Commentaire Qty.: 0.0420 GALLON(s)/Unit Total: 0.0420 GALLON(s)








Fibre de verre Miapoxy 66

N° de Lot: 1-5502-1










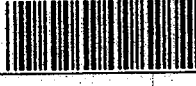
ate: Mercredi, 2007-02-28 11:16:50

Utilisateur: Marc Dubé

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.		Nom Dessin: SPACEPOD BODY	
Numéro Job: 41094		Numéro Article: DKC134-0055	
Numéro Job:			
# Séq.:	Machine ou Opération:	Description :	
51.0	PRÉPARATION 3	PRÉPARATION DU MATÉRIEL DART	
			
<p>Commentaire Setup: 0.00Hr / Run: 5.0000Min Total Run : 0.0833Hrs</p> <p>PRÉPARATION DU MATÉRIEL</p> <p>Faire la préparation de la résine selon les quantités requises, mix ratio 2% de Catalyst N° DDM-9 par quantité de résine N° 411-350.</p> <p>Date: <u>21/05/07</u> Heure Début: _____ Heure Fin: _____ Sceau: </p>			
52.0	AAC0448	Spacer N° D2213	
<p>Commentaire Qty.: 8 UNITE(s)/Unit Total : 8 UNITE(s)</p> <p>Spacer N° D2213 N° de Lot: <u>1-5949-1</u></p>			
53.0	ASSEMBLAGE 3	ASSEMBLAGE GÉNÉRALE DART	
			
<p>Commentaire Setup: 0.00Hrs / Run: 45.0000Min Total Run : 0.7500Hrs</p> <p>ASSEMBLAGE GÉNÉRALE DES PIÈCES</p> <p>Faire l'assemblage des inserts (Spacer) N° D2213 dans les trous prévus à cet effet à l'aide de résine N° 411-350 caractérisée à l'aide de Fibre de verre courte Miapoxy 66.</p> <p>Laminer un patch de 9 oz. sur chacune des 2 zones de 4 spacers pour reboucher les trous</p> <p>Appliquer une pression sur les pièces de 9 oz à l'aide d'un bloc de bois et de pinces autobloquantes</p> <p>Laisser sécher pendant 4 heures minimum.</p> <p>Date: <u>21/05/07</u> Heure Début: _____ Heure Fin: _____ Sceau: </p> <p>Curing Début: _____ Curing Fin: _____</p>			
54.0	AAC0275	Catalyst N° DDM-9	
<p>Commentaire Qty.: 0.0096 PINTE(s)/Unit Total : 0.0096 PINTE(s)</p> <p>Catalyst N° DDM-9</p> <p>N° de Lot: <u>5921</u></p>			
55.0	AAC0324	Résine (411B7530) 411-350 promo. 75min.	
<p>Commentaire Qty.: 0.300 KILOGRAMME(s)/Unit Total : 0.300 KILOGRAMME(s)</p> <p>Résine (411B7530) 411-350 promo. 75min.</p> <p>N° de Lot: <u>1-6032-1</u></p>			

## Feuille de Procédé

Client: DART	Dart Aerospace Ltd.	Nom Dessin: SPACEPOD BODY
Numéro Job: 41094		Numéro Article: DKC134-0055
Numéro Job:		
# Séq.:	Machinerie ou Opération:	Description:
56.0	PRÉPARATION 3	PRÉPARATION DU MATÉRIEL DART
		
Commentaire Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs PRÉPARATION DU MATÉRIEL		
Faire la préparation de la résine selon les quantités requises, mix ratio 2% de Catalyst N° DDM-9 par quantité de résine N° 411-350.		
Date: 21/03/07	Heure Début:	Heure Fin: Sceau: 
57.0	LAMINAGE.	LAMINAGE PIÈCE DART
		
Commentaire Setup: 0.00Hrs/ Run: 55.0000Min Total Run : 0.9167Hrs FAIRE LE LAMINAGE DES TISSUS		
Retirer les pièces et blocs de bois		
Faire le laminage d'un pli de 9.7 oz 7781 S-Glass sur le contour de la pièce. Selon le dessin.		
Laisser sécher pendant 4 heures minimum.		
Date: 21/03/07	Heure Début:	Heure Fin: Sceau: 
Curing Début: Curing Fin:		
58.0	FINITION 3	FINITION PIÈCE DART
		
Commentaire Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs FINITION PIÈCE DART		
Repercer les 8 trous des spacers afin de les déboucher		
Sabler les surfaces de la pièce pour aider à l'adhésion du primer et enlever les imperfections.		
59.0	AAC0671	Dupont Primer N° 1104S
Commentaire Qty.: 0.500 GALLON(s)/Unit Total : 0.5000 GALLON(s) Dupont Primer N° 1104S		
N° de Lot: 1-5931-2		
60.0	AAC0670	Dupont Activation N° 7975S
Commentaire Qty.: 1.000 PINTE(s)/Unit Total : 1.0000 PINTE(s) Dupont Activation N° 7975S		
N° de Lot: 1-6041-1		

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: SPACEPOD BODY

Numéro Job: 41094

Numéro Article: DKC134-0055

Numéro Job:



# Séq.: Machine ou Opération: Description:

61.0 AAC0672 Dupont Reducer N° 12375S

Commentaire Qty.: 0.1250 GALLON(s)/Unit Total: 0.1250 GALLON(s)  
Dupont Reducer N° 12375S

N° de Lot: 1- 53A0-2

62.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART

Commentaire Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run: 0.0000Hrs  
PRÉPARATION DU MATÉRIEL DART

Nettoyages Qty 1 23-03-07



MAR 23 2007



Bien brasser les trois contenants servant à faire le mélange du primer gris N° 1104S et ensuite faire le mélange selon les instructions du fabricant.

63.0 PEINT/PRIMER2 PEINTURE / PRIMER DART

Commentaire Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs  
PEINTURE / PRIMER DARTAppliquer une couche de primer Dupont N° 1104S ( 7975S Activator, 12375S Reducer ) selon I.G. #  
Application du primer

Laisser sécher pendant 3 heures minimum

MAR 23 2007

Date: \_\_\_\_\_ Heure Début: \_\_\_\_\_ Heure Fin: \_\_\_\_\_ Sceau: \_\_\_\_\_



64.0 AAC0451 Label N° D0600-142

Commentaire Qty.: 1 UNITE(s)/Unit Total: 1 UNITE(s)  
Label N° D0600-142 N° de Lot: \_\_\_\_\_

65.0 AAC0444 Surface Veil

Commentaire Qty.: 1.00 VERGE CAR(s)/Unit Total: 1.00 VERGE CAR(s)  
Surface Veil N° de Lot: \_\_\_\_\_

66.0 AAC0501 Résine Mia-Poxy

Commentaire Qty.: 0.015 GALLON(s)/Unit Total: 0.015 GALLON(s)  
Résine Mia-Poxy N° de Lot: \_\_\_\_\_

MIA



67.0 AAC0502 Durcisseur 95 Pour Résine Mia-Poxy

Commentaire Qty.: 0.030 PINTE(s)/Unit Total: 0.030 PINTE(s)  
Durcisseur 95 Pour Résine Mia-Poxy N° de Lot: \_\_\_\_\_








68.0 ASSEMBLAGE 3 ASSEMBLAGE GÉNÉRALE DART

Commentaire Setup: 0.00Hrs/ Run: 15.0000Min Total Run: 0.2500Hrs  
ASSEMBLAGE GÉNÉRALE DART

Coller le label D0600-142 sur le spacepod en plaçant un surface veil en dessous et par dessus le label à l'aide de résine Mia-Poxy. Selon I.F. # DKC134-0019-13

date: Mercredi, 20C7-02-28 11:16:50  
Utilisateur: Marc Dubé








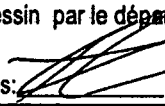



## Feuille de Procédé

Client: DART Dart Aerospace Ltd.		Nom Dessin: SPACEPOD BODY	
Numéro Job: 41094		Numéro Article: DKC134-0055	
Numéro Job:			
# Séq.:	Machinerie ou Opération:	Description:	
	Date: _____ Heure début: _____ Heure fin: _____ Sceau: 	<i>N/A</i>	
69.0	AC0058	Polysoft 1.3 kg # 003012 Sikkens	
Commentaire Qty.: 0.020 UNITE(s)/Unit Total: 0.020 UNITE(s) Polysoft 1.3 kg # 003012 Sikkens			
N° de Lot: <u>1-6044-1</u>			
70.0	AC0059	Durcisseur Polysoft #004009 Sikkens	
Commentaire Qty.: 0.078 UNITE(s)/Unit Total: 0.078 UNITE(s) Durcisseur Polysoft #004009 Sikkens			
71.0	FINITION 3	FINITION PIÈCE DART	
			
Commentaire Setup: 0.00Hrs/ Run: 90.0000Min Total Run: 1.5000Hrs FINITION GÉNÉRALE			
Faire les réparations de finition s'il y a lieu à l'aide du Sikkens			
Faire un léger sablage (Grit 220) de toute les surfaces.			
Date: <u>28-3-07</u> Heure Début: _____ Heure Fin: _____ Sceau: 			
72.0	AAC0671	Dupont Primer N° 1104S	
Commentaire Qty.: 0.2500 GALLON(s)/Unit Total: 0.2500 GALLON(s) Dupont Primer N° 1104S N° de Lot: <u>1-5931-2</u>			
73.0	AAC0670	Dupont Activator N° 7975S	
Commentaire Qty.: 0.5000 PINTE(s)/Unit Total: 0.5000 PINTE(s) Dupont Activator N° 7975S N° de Lot: <u>1-6041-1</u>			
74.0	AAC0672	Dupont Reducer N° 12375S	
Commentaire Qty.: 0.0625 GALLON(s)/Unit Total: 0.0625 GALLON(s) Dupont Reducer N° 12375S N° de Lot: <u>1-6390-2</u>			
75.0	PRÉPARATION 1	PRÉPARATION DU MATÉRIEL DART	
			
Commentaire Setup: 0.00Hrs/ Run: 15.0000Min Total Run: 0.2500Hrs PRÉPARATION DU MATÉRIEL			
Masquer le label.			
Bien brasser les trois contenants servant à faire le mélange du primer gris N° 1104S et ensuite faire le mélange selon les instructions du fabricant.			

MAR 28 2007



## Feuille de Procédé

Client: DART	Dart Aerospace Ltd.	Nom Dessin: SPACEPOD BODY
Numéro Job: 41094		Numéro Article: DKC134-0055
Numéro Job:		
# Séq.:	Machine ou Opération:	Description :
76.0	PEINT/PRIMER2	PEINTURE / PRIMER DART
		
Commentaire Setup: 0.00Hr / Run: 90.0000Min Total Run : 1.5000Hrs APPLICATION DE PRIMER  Appliquer deux couche de primer Dupont N° 1104S ( 7975S Activator, 12375S Reducer ) selon les instruction du manufacturier, en prenant bien soin d'attendre 10 minutes entre les couches.  Laisser sécher pendant 3 heures minimum MAR 28 2007 Date: _____ Heure Début: _____ Heure Fin: _____ Sceau: 		
77.0	INSPECTION 3	INSPECTION PIÈCE DART
		
Commentaire Setup: 0.00Hr / Run: 15.0000Min Total Run : 0.2500Hrs INSPECTION GÉNÉRALE  Faire l'inspection générale de la pièces selon le dessin par le département de la qualité. Date: 3-4-07 Sceau:  Initiales: 		
78.0	EMBALLAGE 3	EMBALLAGE PIÈCE DART
		
Commentaire Setup: 0.00Hr / Run: 0.0000Min Total Run : 0.0000Hrs EMBALLAGE PIÈCE DART  Faire l'emballage dans le contenant approprié. Quantité: 1 Date: 3/4/07 Sceau: 		
Quantité: _____ Date: _____ Sceau: _____		

Date: Monday, 4/16/2007 2:25:13 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SPACEPOD BODY RH
Job Number : 31769A	
Estimate Number : 12596	
P.O. Number :	Part Number : D31882M
This Issue : 4/16/2007 S.O. No. :	Drawing Number : D3188 REV.E
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : E
Previous Run : 31812A	Material :
Written By :	Due Date : 5/5/2007 Qty: 1 Um: Each
Checked & Approved By : <i>[Signature]</i>	
Comment : Est Rev: A New issue ecn882 06-11-30 EC	
est rev B rev D dwg 07.03.07 ec	
est rev C rev E dwg 07.04.16 EC	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	D2213	Aluminum Spacer
-----	-------	-----------------



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)  
 Ship To Delastek

8	D2213	Spacer	Batch: _____
---	-------	--------	--------------

2.0	PG	PURCHASING
-----	----	------------



Comment: PURCHASING  
 Issue P/O: \_\_\_\_\_  
 Description: D3188-2M BODY  
 SHIP: D2213 Spacers  
 Supplier: Delastek  
 Conformity Certificate and Process sheet required  
 Ship 2 Items from Previous steps

*w/o 30044*

3.0	D31882P	Spacepod Body
-----	---------	---------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
 Spacepod Body

4.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1  
 Receive and inspect for transit damage. Ensure a copy of certification of conformity and process sheet from Delastek is attached.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



Date: Monday, 4/16/2007 2:25:14 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD BODY RH

Job Number: 31769A

Part Number: D31882M

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

Inspect dimensions as per Dwg D3188 .Visual inspection. Check for void spot and pins.

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



*in 8704-27*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**DART**

RELEASED

07.04.02

DESIGN	DRAWN BY	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA		
JB	CB	DRAWING NO.	REV. E	
CHECKED CE	APPROVED [Signature]	D3188	SHEET 1 OF 11	
DATE 07.04.02		TITLE SPACEPOD BODY	SCALE NTS	
A	03.04.03	NEW ISSUE		
B	06.10.06	UPDATED DWG TO MATCH PRODUCT ADDED D3188-1M/-2M/-3M/-5/-6/-7		
C	06.12.13	REMOVED D0600-XXX LABELS		
D	07.02.22	UPDATE DIMENSIONS		
E	07.04.02	ADD HYSOL/FIBER OPTION ON SHEET 11		

**GENERAL NOTES:**

- 1) REFERENCE DIMENSIONS MATCH AIRCRAFT CONTOUR AND DOOR OPENING
- 2) LAMINATE PER DART QSI 006. LAMINATION SCHEDULE PER THIS DRAWING
- 3) MATERIALS:

RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40

FIBER: 9.7 oz 7781 WEAVE "S" GLASS (9 oz SATIN)  
12 oz UNIDIRECTIONAL FIBERGLASS ("12 oz UNIDIRECTIONAL")  
18 oz ROVING "E" GLASS (18 oz CLOTH)  
OWENS CORNING MILLED FIBERS, "E" GLASS  
3M K20 GLASS BUBBLESFOAM: A500 CORE CELL  
OR DIVINYCELL  
OR AIREX  
OR KLEGECELL  
FILL VOIDS IN FOAM WITH PASTE MADE FROM MILLED FIBERS & RESIN

- 4) MOLD SCHEDULE:

PART	LAYUP	TRIM AND DRILL
D3188-1M/-1/-5	DT8003	DT8501
D3188-2M/-2/-6	DT8004	DT8502
D3188-3M/-3/-7	DT8500	DT8500

- 5) APPLY ANTI-SKID PAINT TO TOP SURFACE OF PODS PER QSI 005 4.4
- 6) FINISH: INSIDE/OUTSIDE WITH GREY DUPONT HIGHBUILD PRIMER 1144-S

ALL DIMENSIONS ARE IN INCHES

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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WORK ORDER

NO 317631A

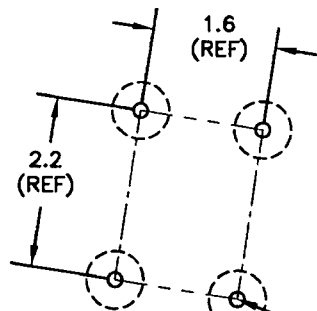
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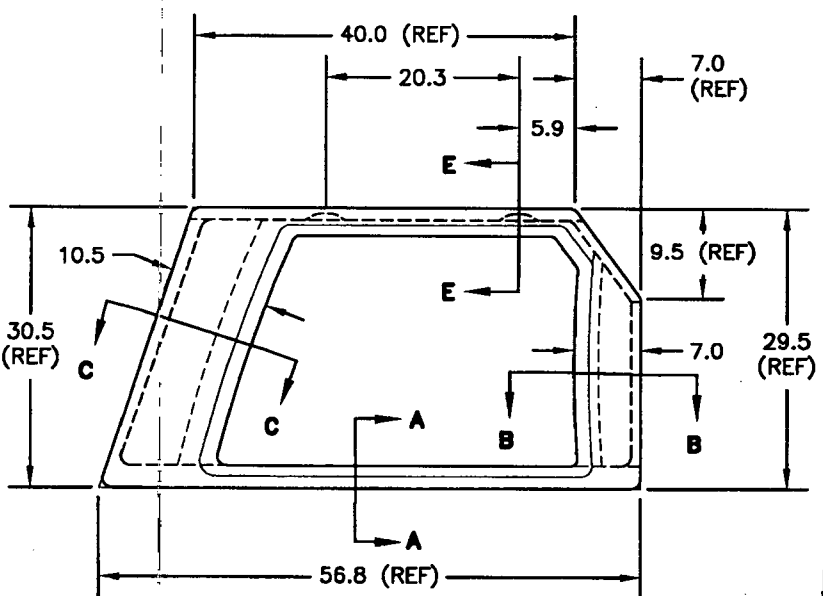
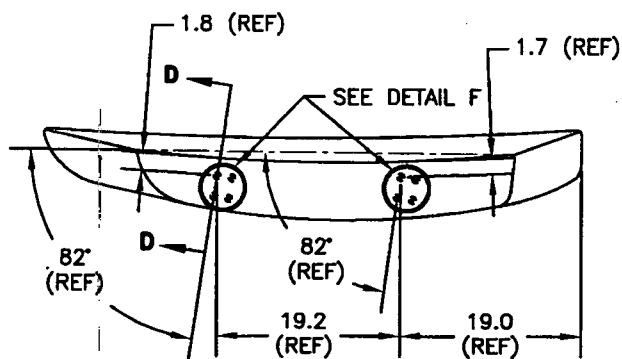
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DATE	07.04.02	TITLE	SPACEPOD BODY	REV. E SHEET 2 OF 11
		SCALE	NTS	

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07.04.01

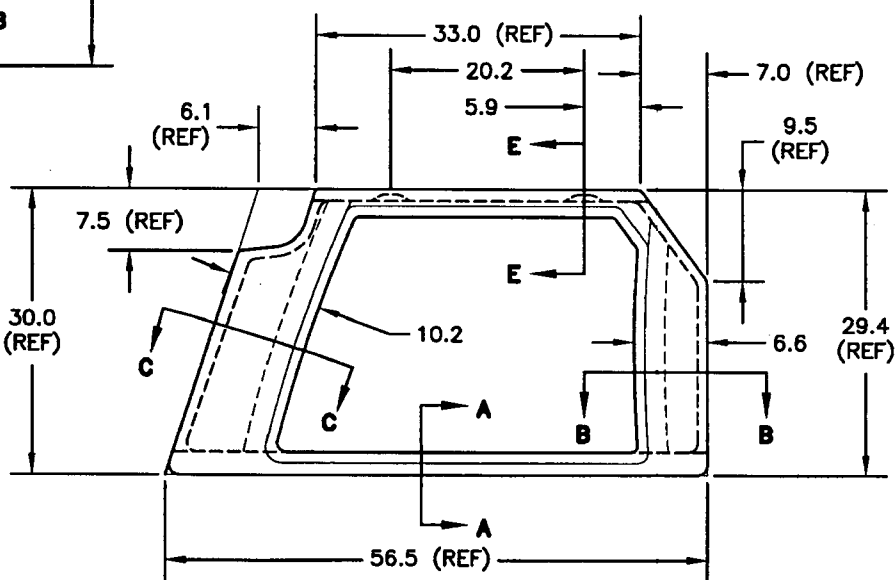
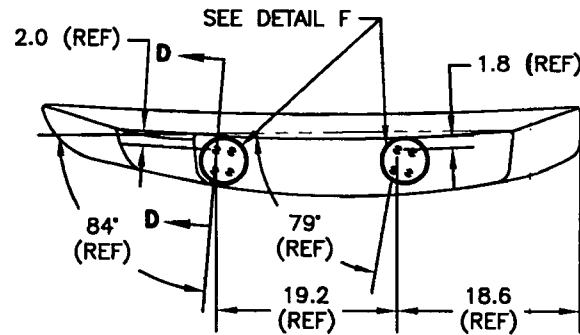


**DETAIL E**

INSTALL  
D2213 SPACER  
(8 PLACES)  
(SEE SECTION D-D)



**D3188-1M SPACEPOD BODY**



**D3188-3M SPACEPOD BODY**

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WORK ORDER  
31769

**D3186-1M/-3M NOTES:**

- 1) REFERENCE DIMENSIONS ARE FROM DT8003/DT8500 AND DT8501.
- 2) SEE SHEET #4 FOR SECTION VIEWS.

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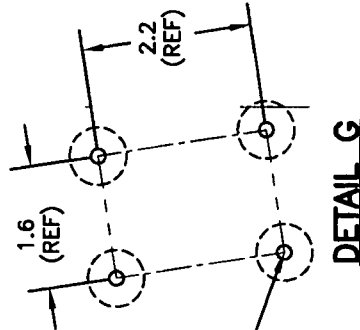
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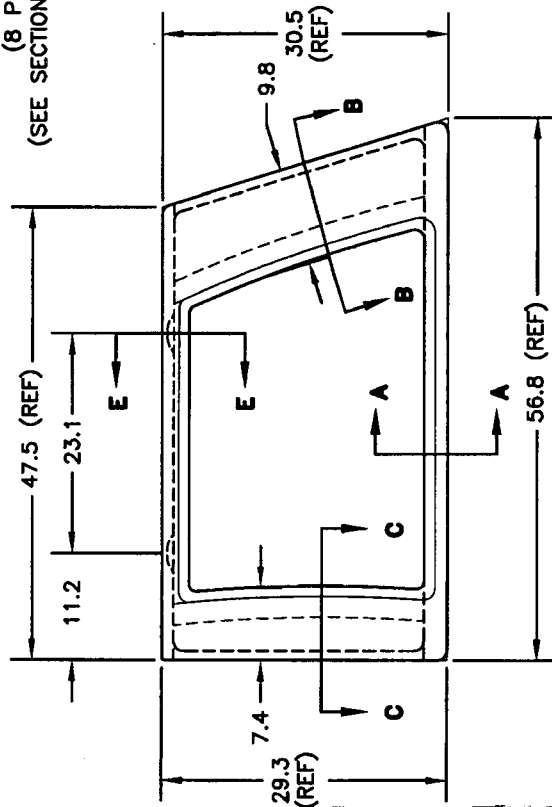
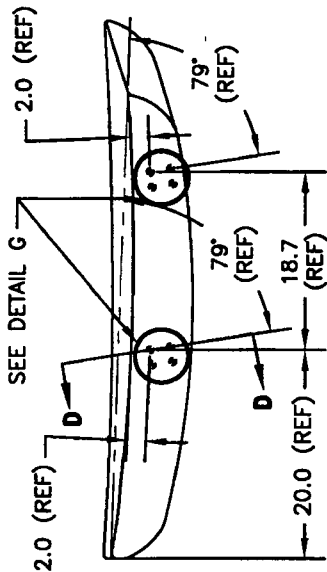
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DATE <b>07.04.02</b>	TITLE <b>SPACEPOD BODY</b>		SCALE <b>NTS</b>

RELEASED

07.04.02 **[Signature]**



INSTALL  
D2213 SPACER  
(8 PLACES)  
(SEE SECTION D-D)



**D3188-2M SPACEPOD BODY**

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WORK ORDER  
NO. **31769**

D3188-2M NOTES:  
1) REFERENCE DIMENSIONS ARE FROM DT8004 AND DT8502.  
2) SEE SHEET #4 FOR SECTION VIEWS.

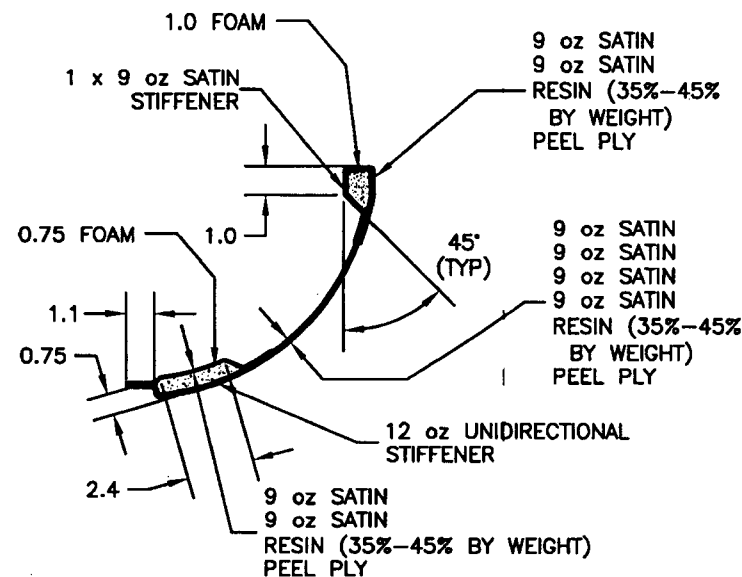
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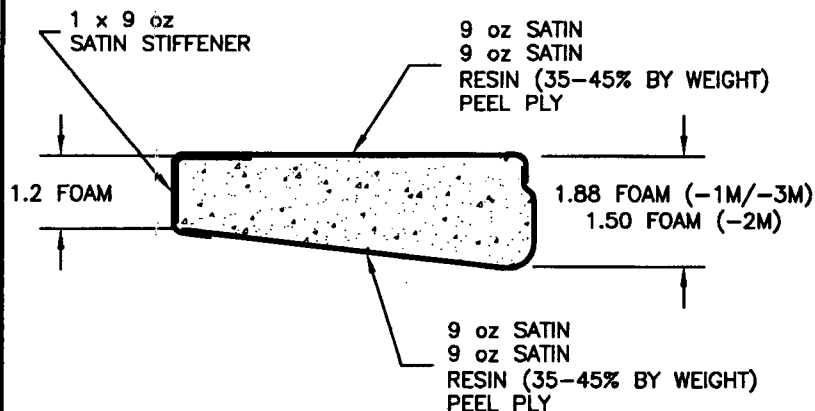
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		TITLE	SPACEPOD BODY	SHEET 4 OF 11
				SCALE
				NTS

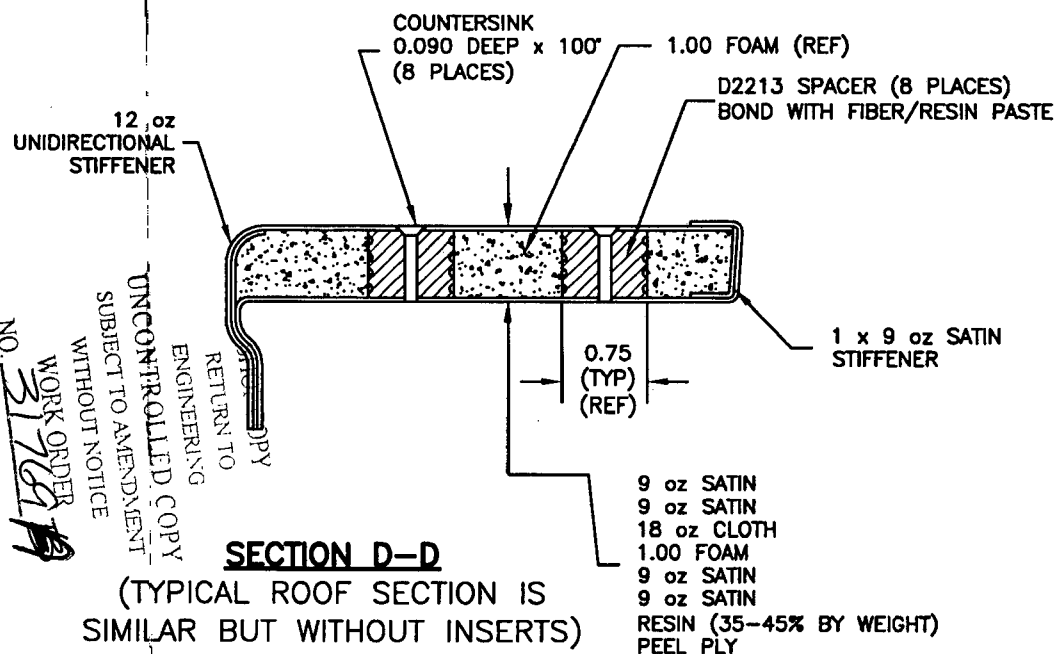
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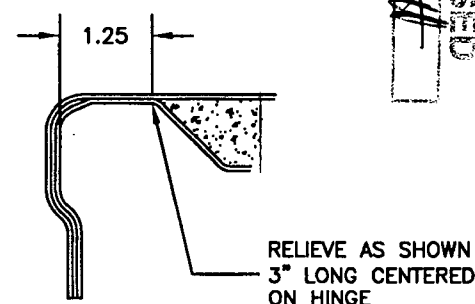
**SECTION B-B**  
(SECTION C-C OPPOSITE)



**SECTION A-A**  
(TYPICAL FLOOR SECTION)



**SECTION D-D**  
(TYPICAL ROOF SECTION IS  
SIMILAR BUT WITHOUT INSERTS)



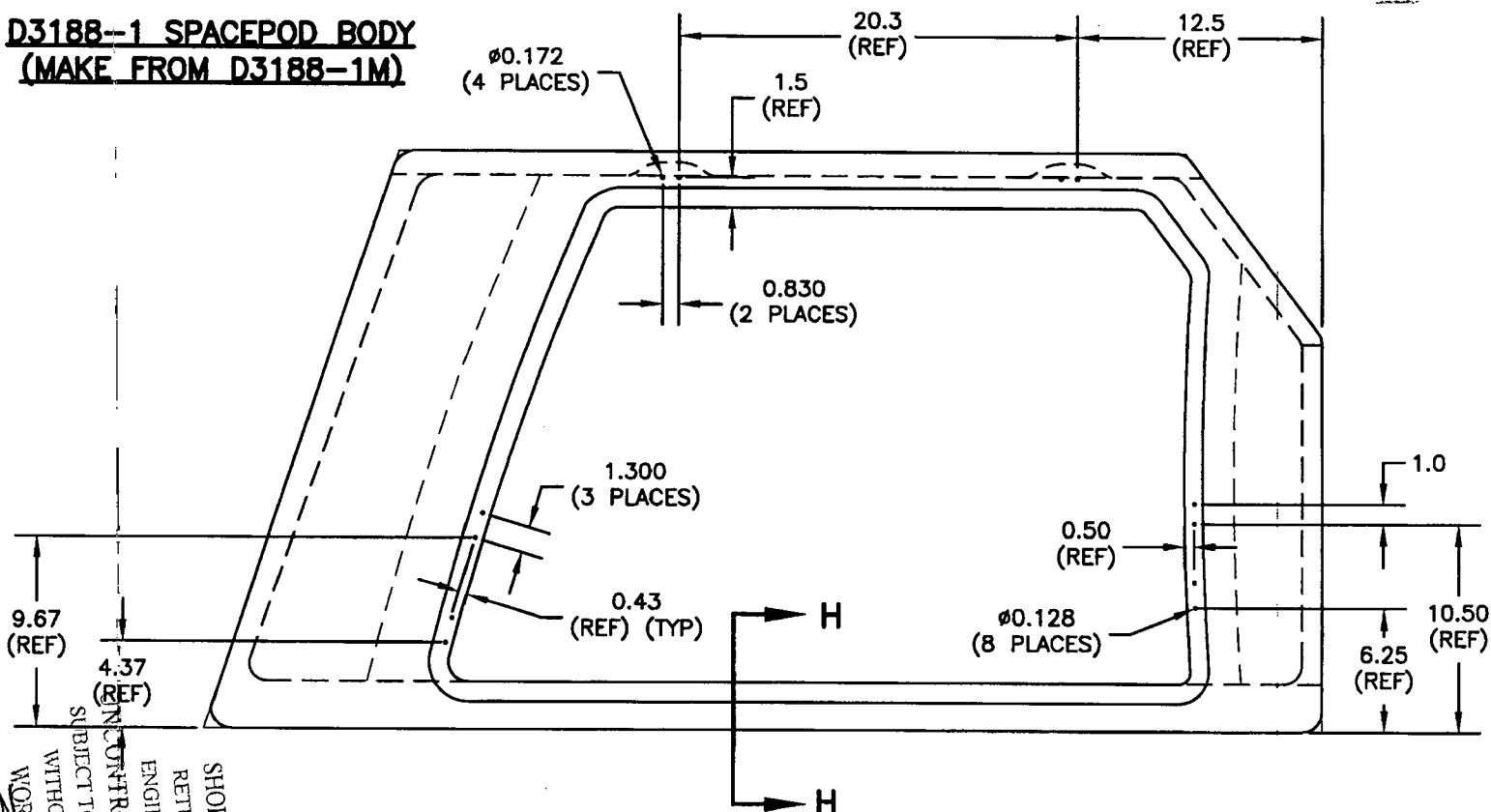
**SECTION E-E**  
(2 PLACES PER POD)

**DART**

DESIGN	DRAWN BY	DART AEROSPACE LTD
JB	CB	HAWKESBURY, ONTARIO, CANADA
CHECKED LE	APPROVED [Signature]	DRAWING NO. D3188
DATE 07.04.02	TITLE SPACEPOD BODY	REV. E SHEET 5 OF 11
		SCALE NTS

RELEASED  
07.04.01

**D3188-1 SPACEPOD BODY  
(MAKE FROM D3188-1M)**



**NOTES:**

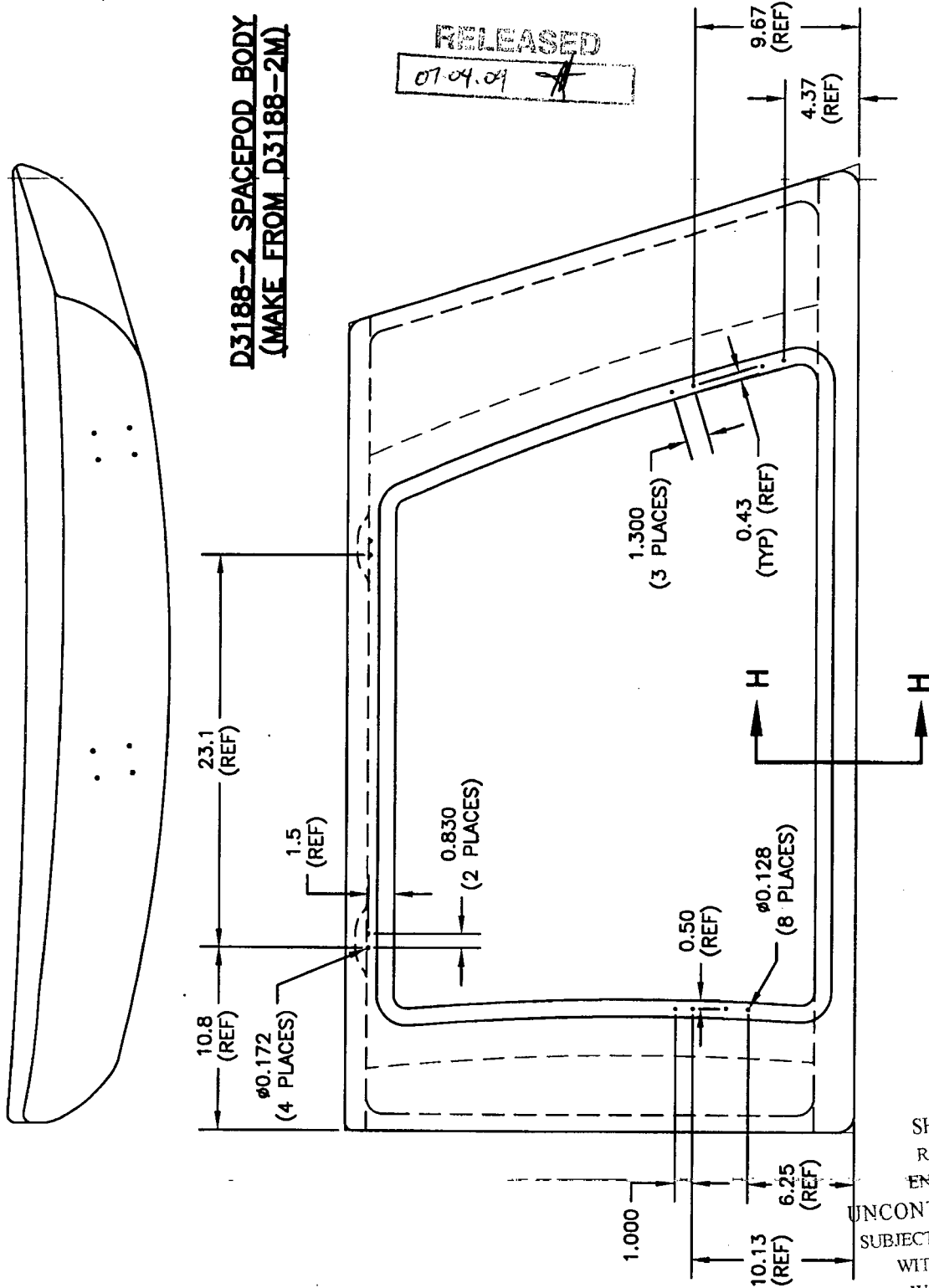
- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-1 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEW

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WORK ORDER  
NO. 31763

**DART**

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CHECKED LE	APPROVED [Signature]	DRAWING NO. D3188	REV. E SHEET 6 OF 11
DATE 07.04.02		TITLE SPACEPOD BODY	SCALE NTS



- NOTES:
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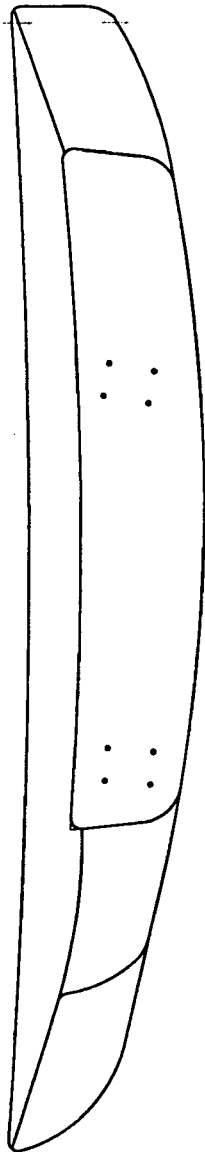


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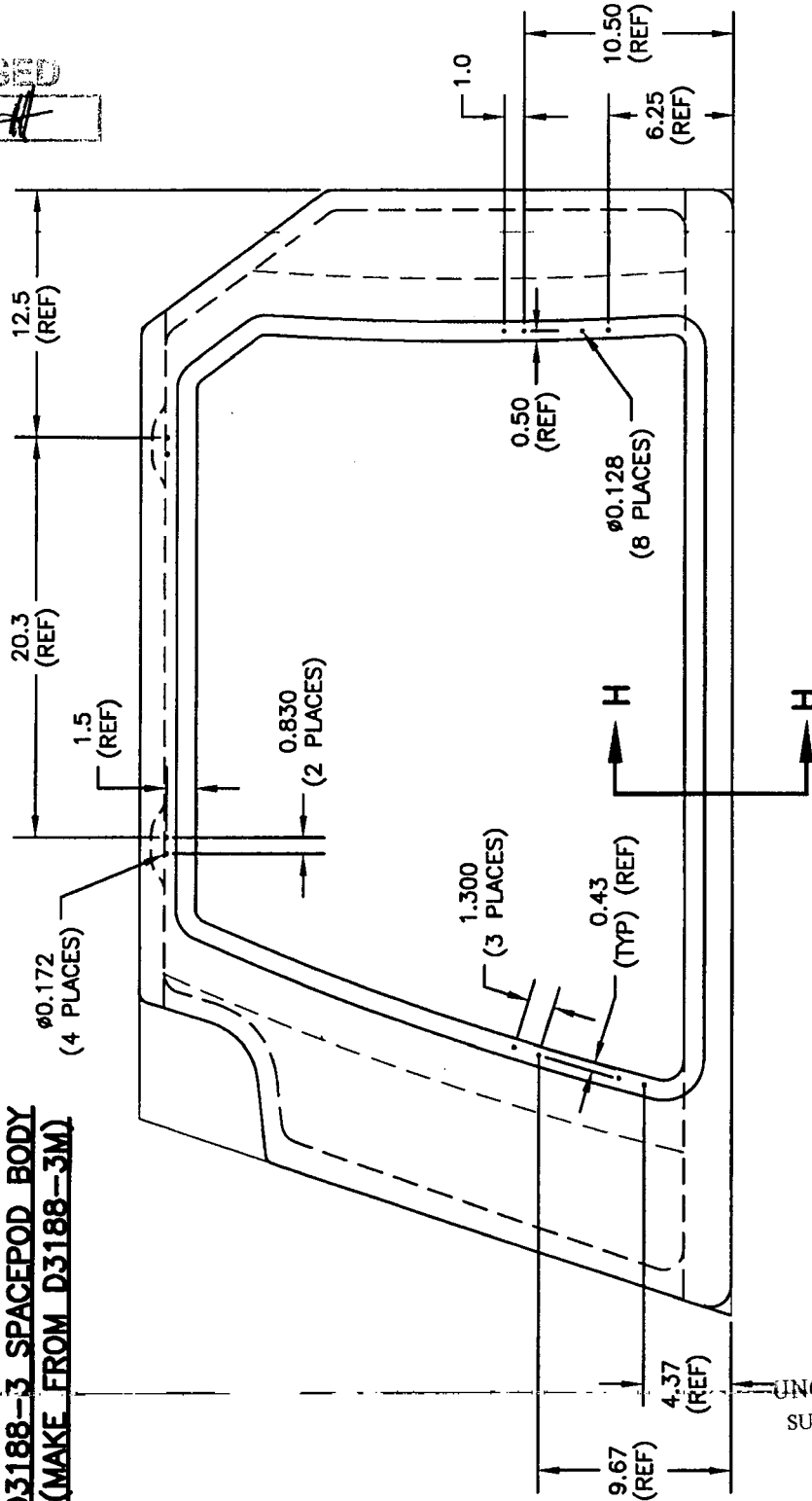
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CHECKED LE	APPROVED H	DRAWING NO. D3188	REV. E SHEET 7 OF 11
DATE 07.04.02	TITLE SPACEPOD BODY		SCALE NTS

RELEASED

07.04.09 H



**D3188-3 SPACEPOD BODY**  
**(MAKE FROM D3188-3M)**



NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-1 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEW

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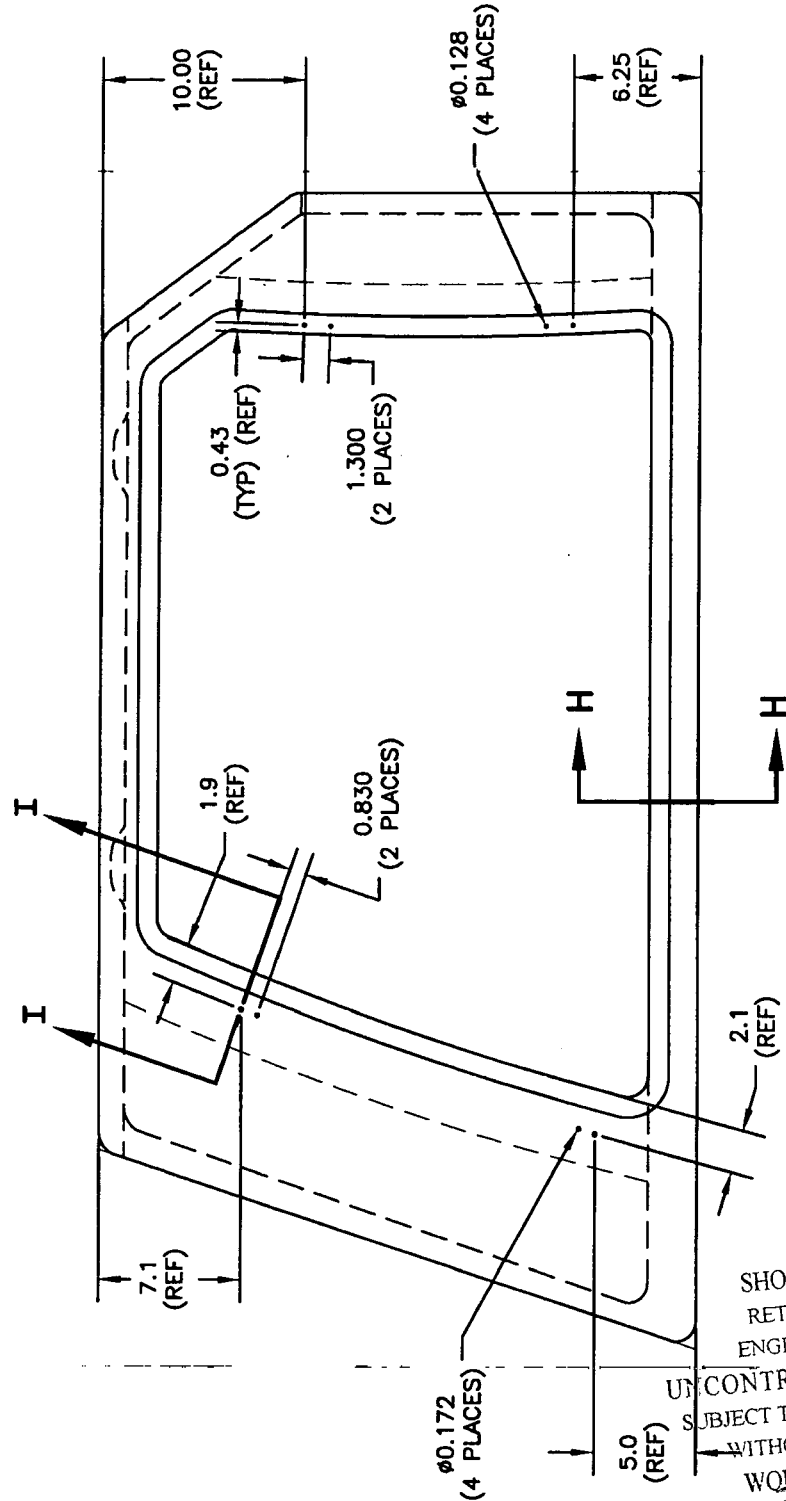
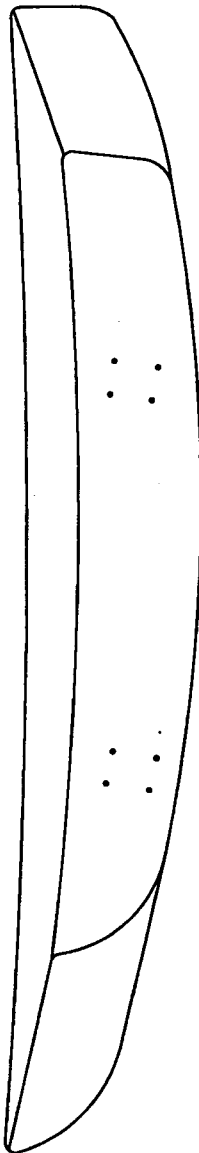
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CHECKED LE	APPROVED [Signature]	DRAWING NO. D3188	REV. E SHEET 8 OF 11
DATE 07.04.02	TITLE SPACEPOD BODY		SCALE NTS

RELEASED

07.04.09 [Signature]

**D3188-5 SPACEPOD BODY  
(MAKE FROM D3188-1M)**



NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-3 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEWS

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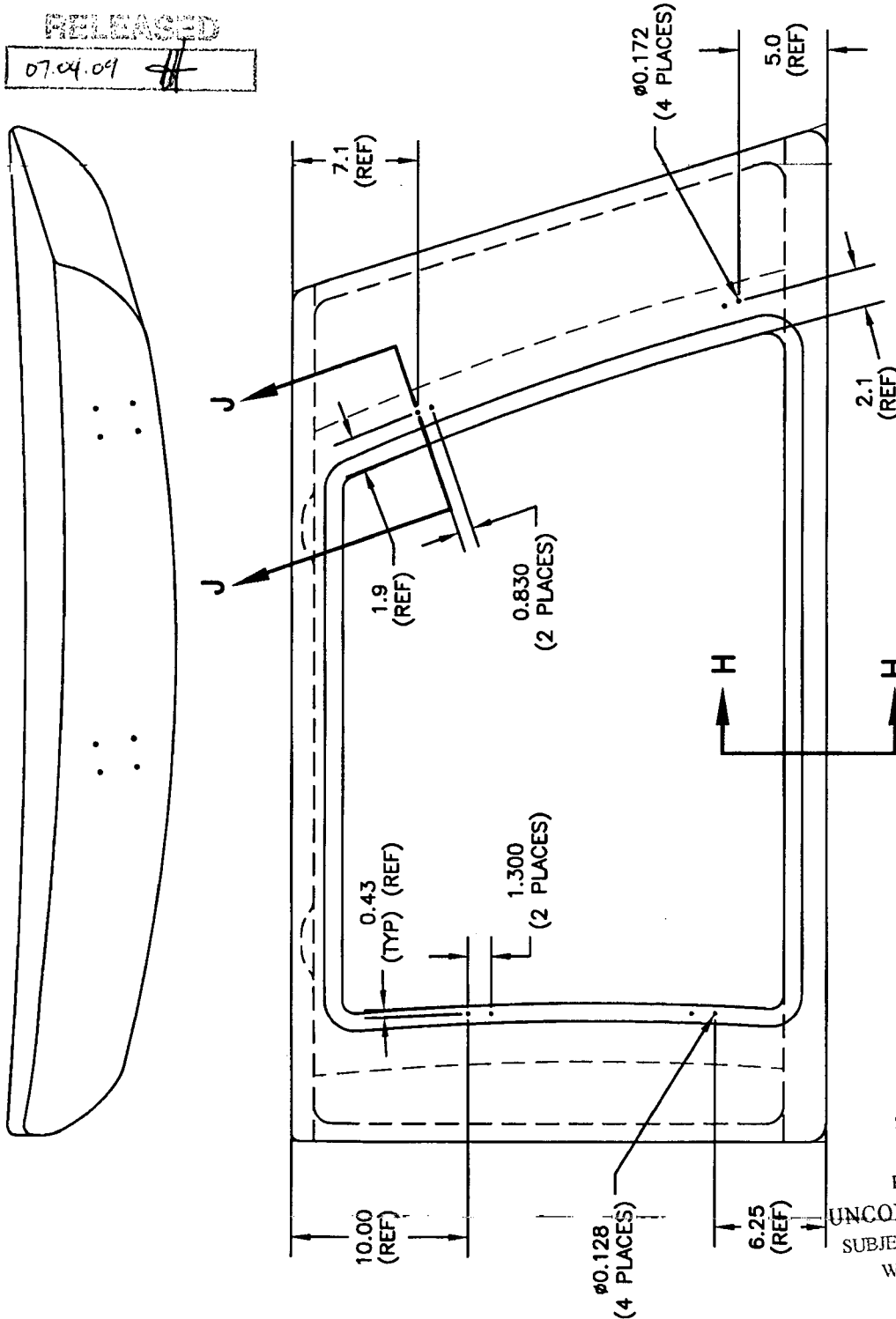
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DATE 07.04.02		TITLE SPACEPOD BODY	SCALE NTS



- NOTES:
- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-4 DOOR DURING ASSEMBLY
  - 2) SEE SHEET #11 FOR SECTION VIEWS

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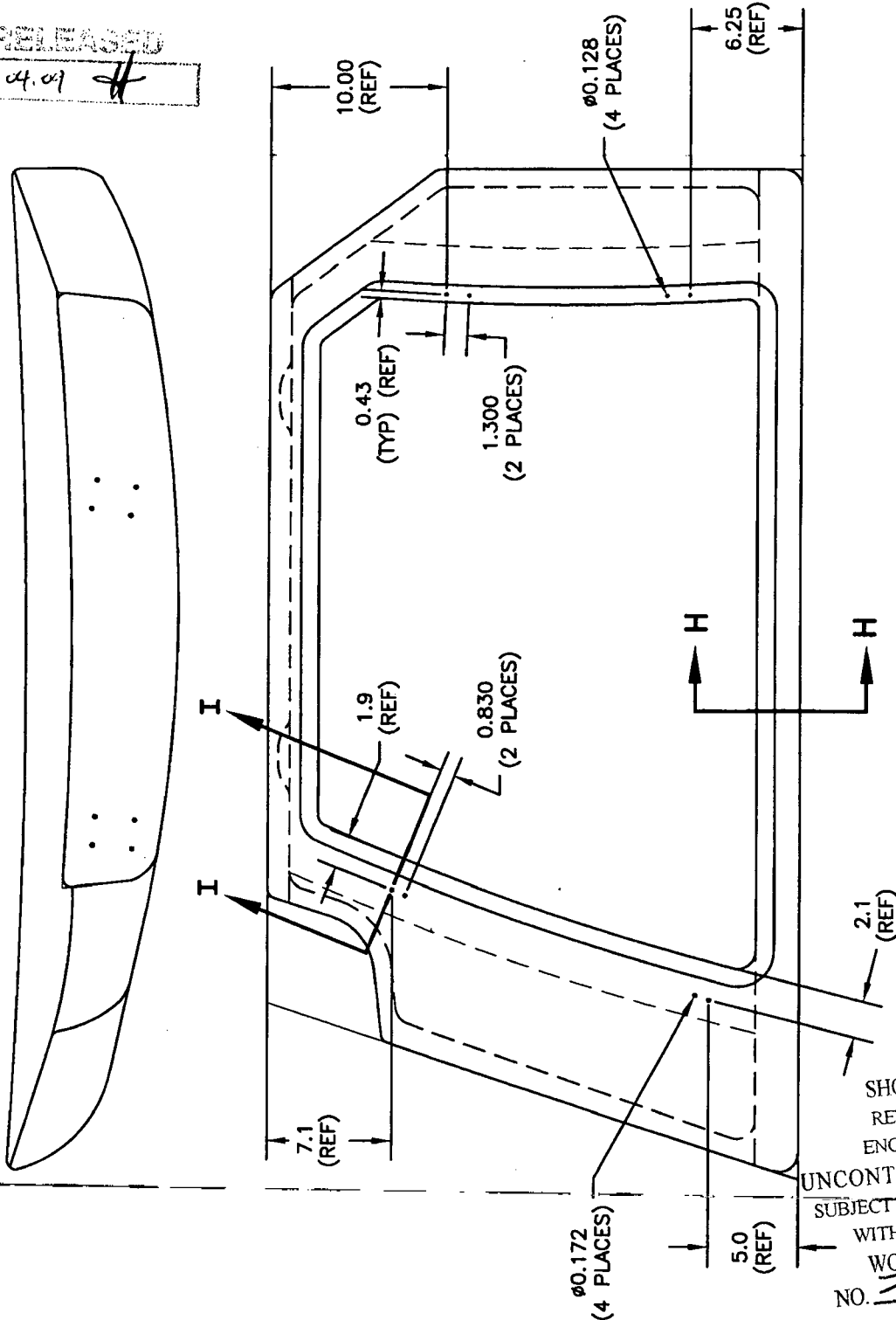
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DATE 07.04.02		TITLE SPACEPOD BODY	SCALE NTS

RELEASED

07.04.02

**D3188-7 SPACEPOD BODY  
(MAKE FROM D3188-3M)**



NOTE:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-3 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEWS

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CHECKED <b>LE</b>	APPROVED <b>[Signature]</b>	DRAWING NO. <b>D3188</b>	REV. E SHEET 11 OF 11
DATE <b>07.04.02</b>		TITLE <b>SPACEPOD BODY</b>	SCALE NTS

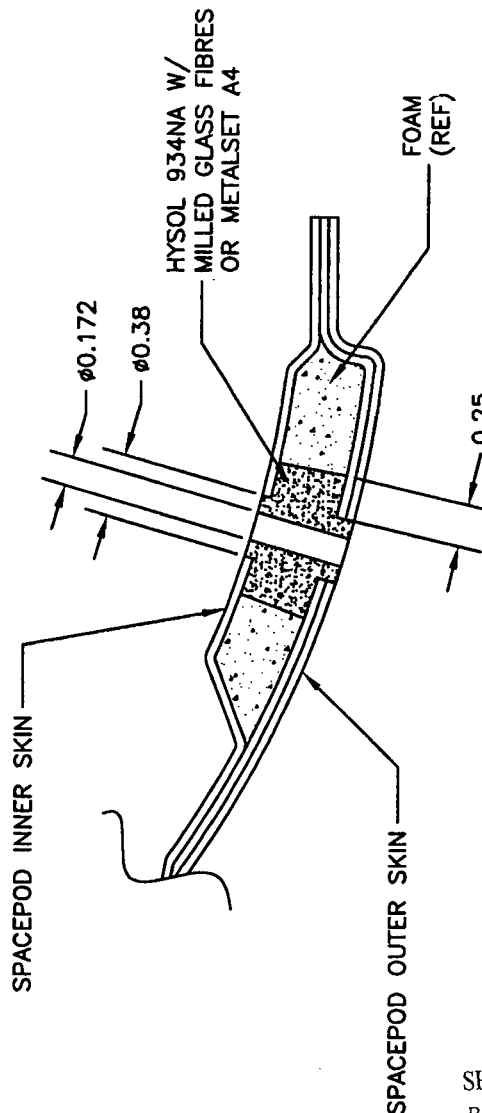
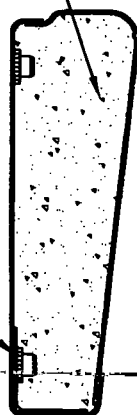
RELEASED

01.04.09 **[Signature]**

INSTALL AKS7-1032-130  
INSERTS (29 PLACES)  
PER D3188-1T1 (D3188-1/-3/-5/-7)  
OR D3188-2T1 (D3188-2/-6)

FOAM  
(REF)

**SECTION H-H**  
(TYPICAL FLOOR SECTION)



**SECTION I-I**  
(SECTION J-J OPPOSITE)  
(4 PLACES PER POD)

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Date: Wednesday, 12/20/2006 1:45:42 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SPACEPOD DOOR RH  
 Job Number : 30034  
 Estimate Number : 12599  
 P.O. Number : N/A Part Number : D31862M  
 This Issue : 12/20/2006 S.O. No. : N/A Drawing Number : D3186 REV *BC LE 07.01.18*  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : N/A Type : PURCHASED PARTS Drawing Revision : *BC LE 07.01.18*  
 Previous Run : 30033 Material : N/A  
 Due Date : 1/26/2007 Qty: 1 Um: Each  
 Written By : *[Signature]*  
 Checked & Approved By : *[Signature]*  
 Comment : Est Rev. A New Issue 06-12-04 ec

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0

PG

PURCHASING



Comment: PURCHASING

Issue P/O: *2767*

Description: D3186-2M Door

Supplier: Delastek

Conformity Certificate and Process sheet required

Ship 3 Items from Previous steps

*C206112121**①*

2.0

D31862P

Spacepod Door



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Spacepod Door

3.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive and inspect for transit damage. Ensure a copy of certification of conformity and process sheet from  
 Delastek is attached.

*[Signature]*  
*07/04/12*

4.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

Inspect dimensions as per Dwg D3186. Visual inspection. Check for void spot and pins.

*ml 07/04/12*

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *GA*

*ml 07/04/12*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: PP Date: 8/10/27  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 12/20/2006 1:45:43 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD DOOR RH

Job Number: 30034

Part Number: D31862M

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



①

Comment: FINAL INSPECTION/W/O RELEASE

207104/27

Job Completion



Le 07-de-27



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

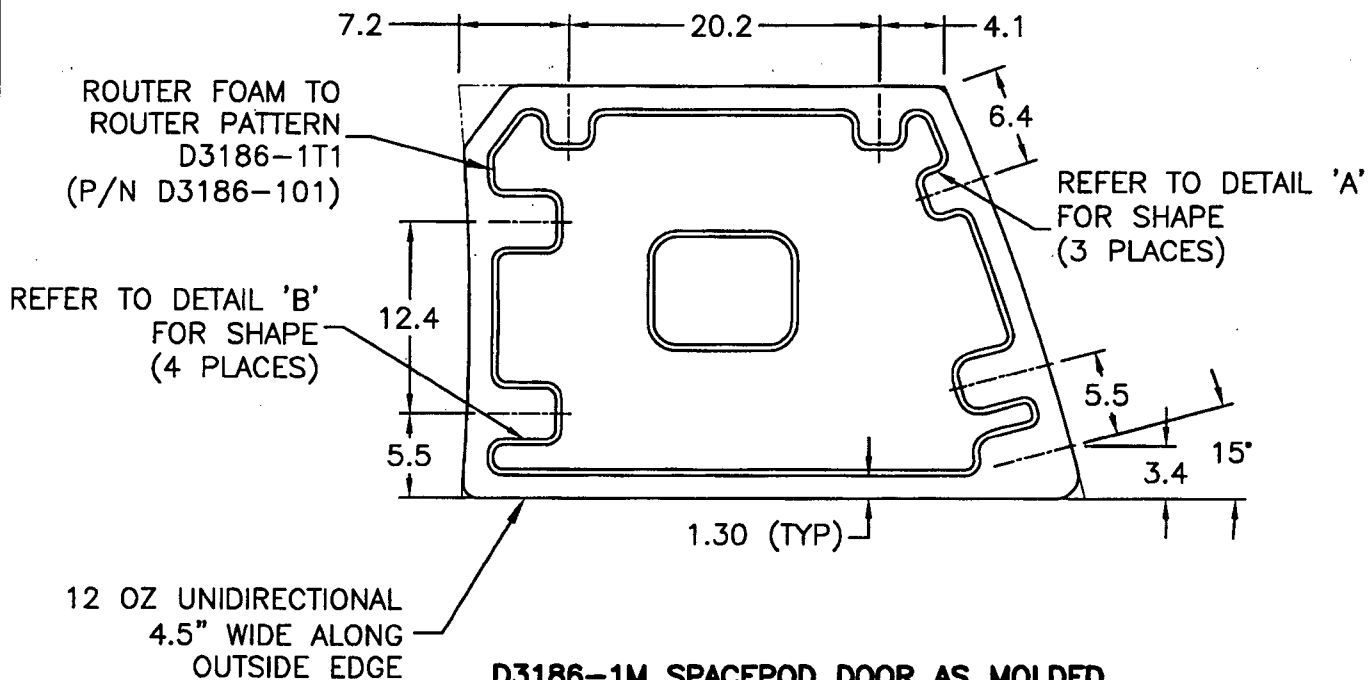
NOTE: Date & initial all entries

**DART**

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CHECKED PH	APPROVED H	DRAWING NO. D3186	REV. C SHEET 1 OF 5
DATE 06.12.13	TITLE SPACEPOD DOOR		SCALE NTS
A	03.03.27	NEW ISSUE	
B	06.09.25	DIMS UPDATED TO MATCH PRODUCT FOAM PATTERN UPDATED D3186-1M/-2M/-3/-4 ADDED	
C	06.12.13	REMOVED D0600-XXX LABELS	

**MAIN LAYUP**

9 OZ SATIN (9 SQ FEET)  
9 OZ SATIN (9 SQ FEET)  
FOAM  
9 OZ SATIN (9 SQ FEET)  
12 OZ UNIDIRECTIONAL  
9 OZ SATIN (9 SQ FEET)  
RESIN (35-45% BY WEIGHT)  
PEEL PLY

**D3186-1M SPACEPOD DOOR AS MOLDED****RELEASED**  
06.12.22 H**NOTES:**

- 1) USE MOLD DT8005 FOR DOOR LAYUP
- 2) RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
- 3) FOAM: 3/8", A500 CORE-CELL OR DIVINYCELL OR AIREX OR KLEGECELL
- 4) FIBRE: 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")  
12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
- 5) LAMINATE PER DART QSI 006 4.0
- 6) LAMINATION-SCHEDULE-PER THIS DRAWING
- 7) FINISH INSIDE/OUTSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S
- 8) ALL DIMENSIONS ARE IN INCHES
- 9) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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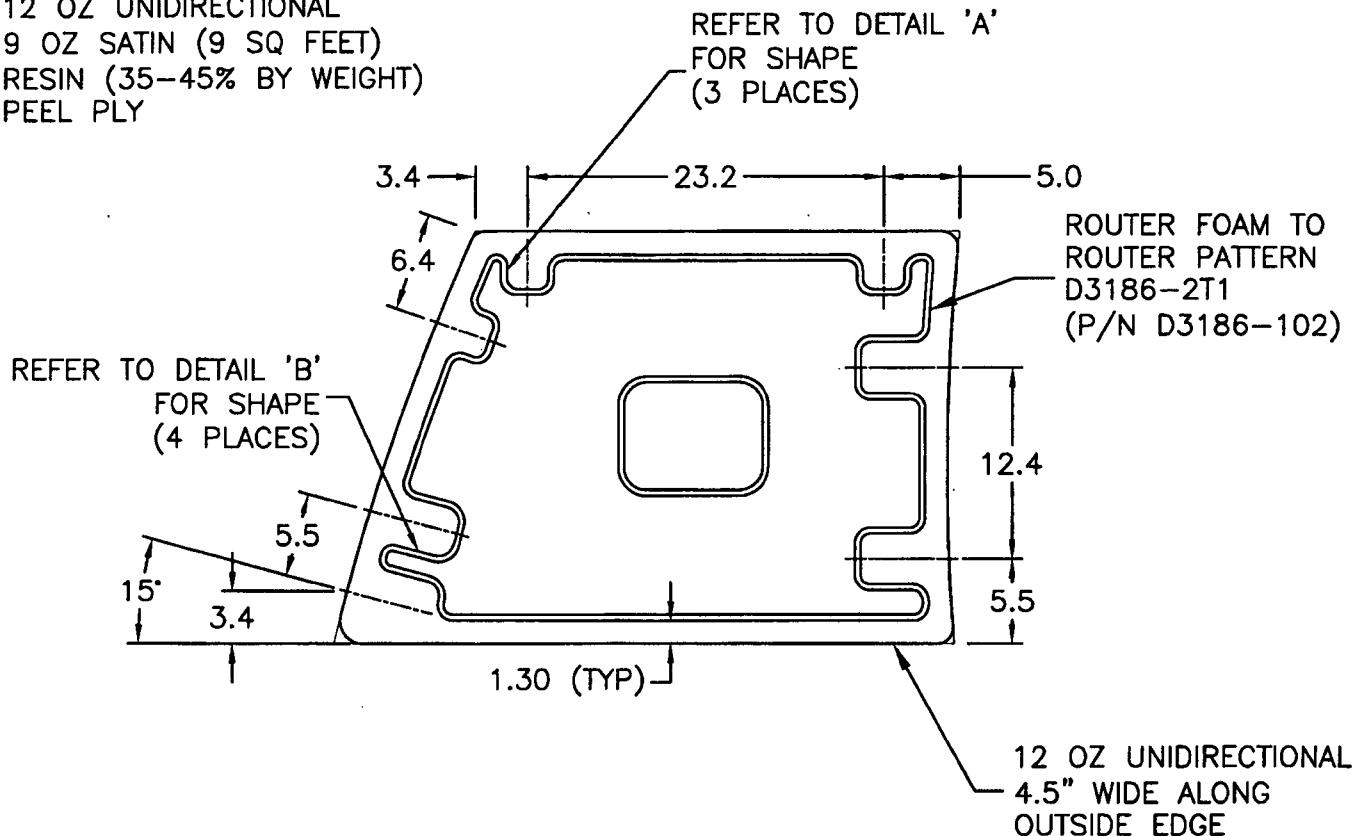
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DATE 06.12.13		TITLE SPACEPOD DOOR	SCALE NTS

MAIN LAYUP

9 OZ SATIN (9 SQ FEET)  
9 OZ SATIN (9 SQ FEET)  
FOAM  
9 OZ SATIN (9 SQ FEET)  
12 OZ UNIDIRECTIONAL  
9 OZ SATIN (9 SQ FEET)  
RESIN (35-45% BY WEIGHT)  
PEEL PLY

**RELEASED**  
06.12.13**D3186-2M SPACEPOD DOOR AS MOLDED**NOTES:

- 1) USE MOLD DT8006 FOR DOOR LAYUP
- 2) RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
- 3) FOAM: 3/8", A500 CORE-CELL OR DIVINYCELL OR AIREX OR KLEGECELL
- 4) FIBRE: 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")  
12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
- 5) LAMINATE PER DART QSI 006 4.0
- 6) LAMINATION SCHEDULE PER THIS DRAWING
- 7) FINISH INSIDE/OUTSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S
- 8) ALL DIMENSIONS ARE IN INCHES
- 9) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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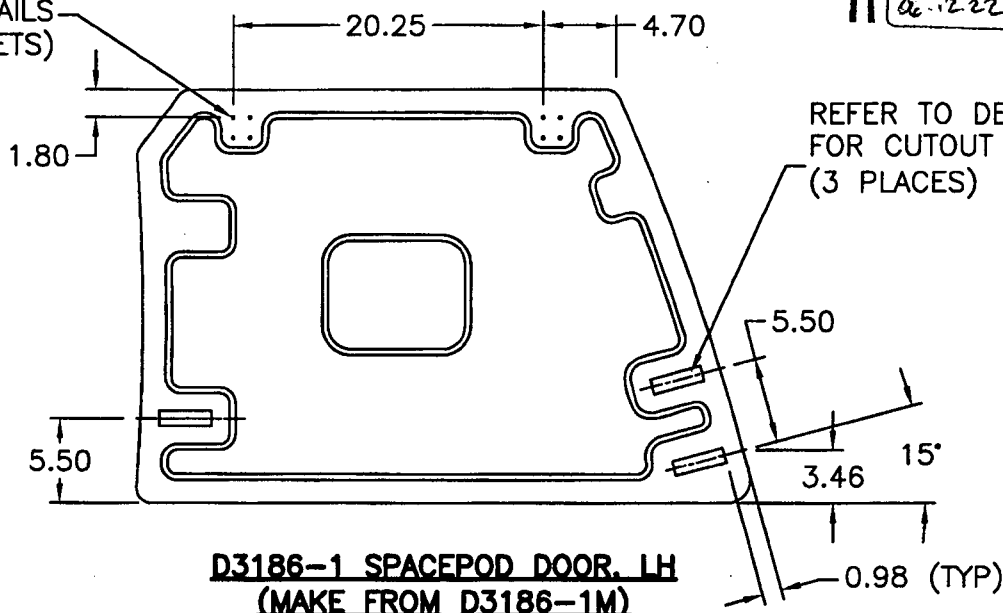
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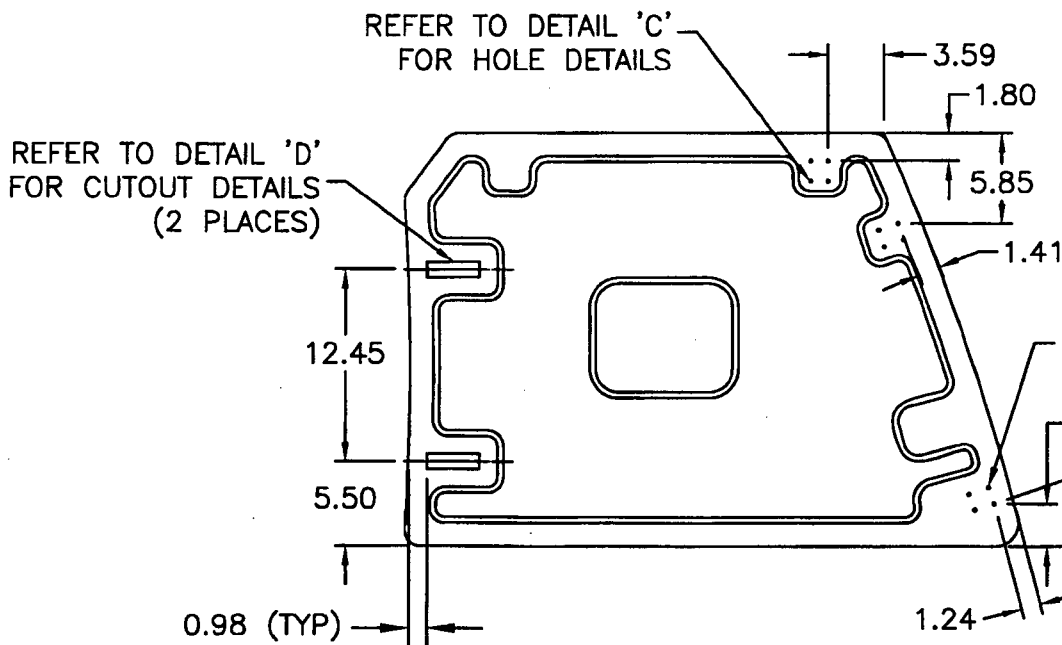


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CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3186	REV. C SHEET 3 OF 5
DATE 06.12.13	TITLE SPACEPOD DOOR		SCALE NTS

REFER TO DETAIL 'C'  
FOR HOLE DETAILS  
(2 SETS)



RELEASED  
*06.12.22*



REFER TO DETAIL 'E'  
FOR HOLE DETAILS  
(2 SETS)

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NO. *30034*

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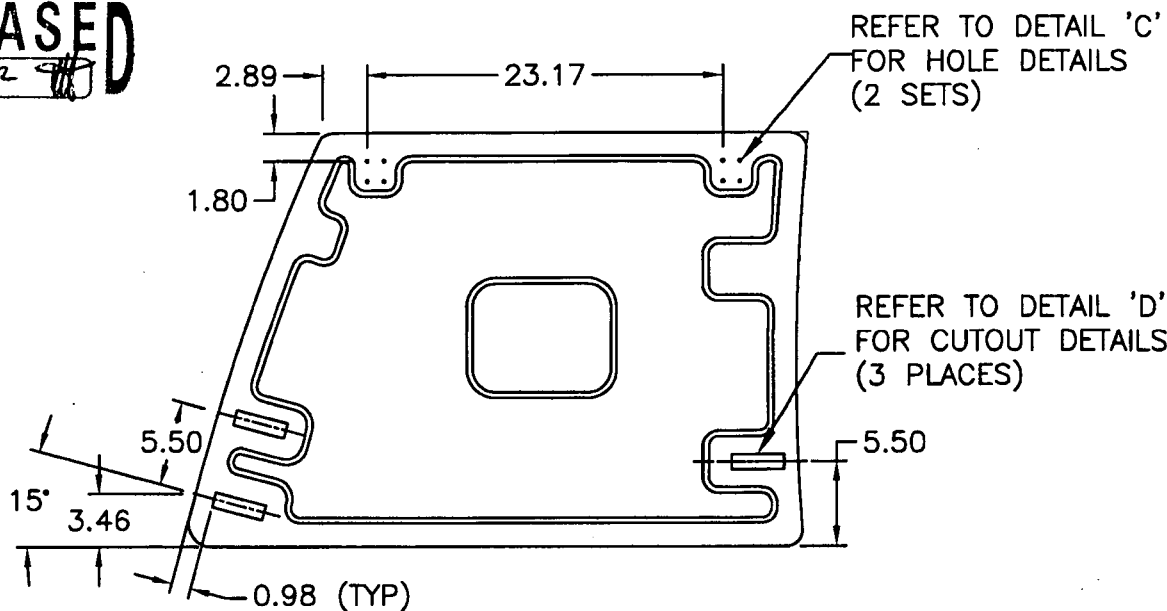
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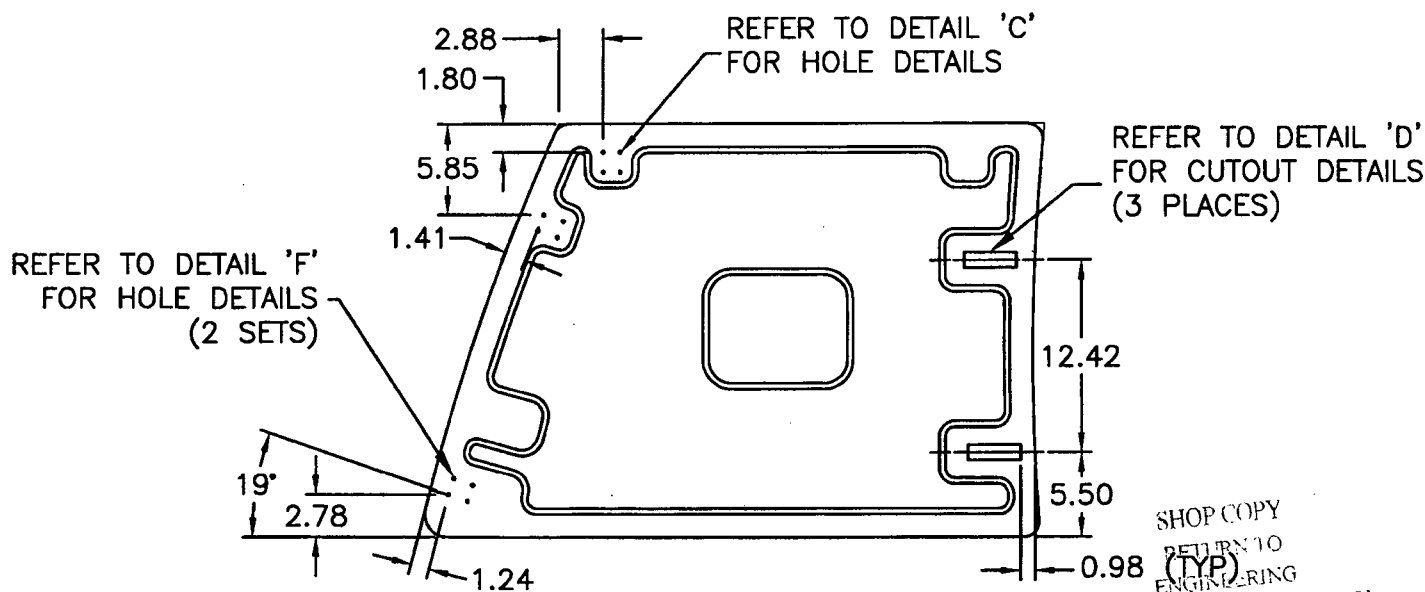


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DATE 06.12.13	TITLE SPACEPOD DOOR		SCALE NTS

RELEASED  
06.12.22



**D3186-2 SPACEPOD DOOR. RH**  
**(MAKE FROM D3186-2M)**



**D3186-4 SPACEPOD DOOR. RH**  
**(MAKE FROM D3186-2M)**

**NOTES:**

- 1) ALL DIMENSIONS ARE IN INCHES
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

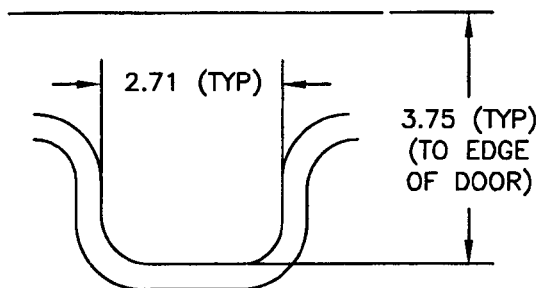
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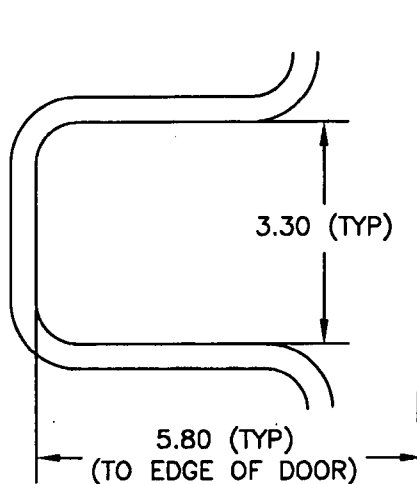
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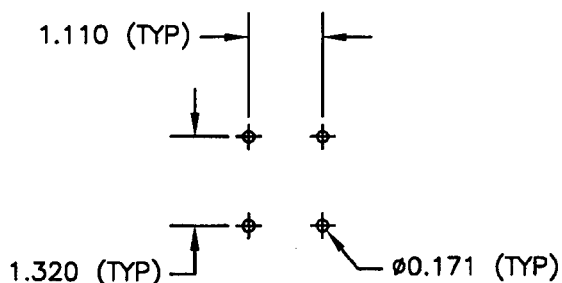
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CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3186	REV. C SHEET 5 OF 5
DATE 06.12.13	TITLE SPACEPOD DOOR		SCALE NTS



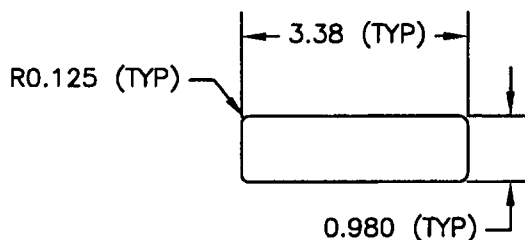
**DETAIL A**



**DETAIL B**

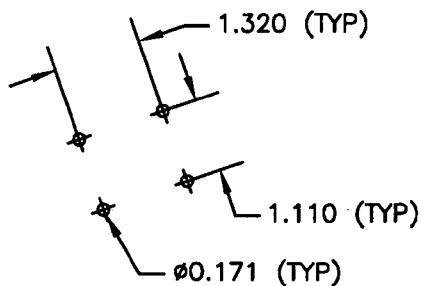


**DETAIL C**

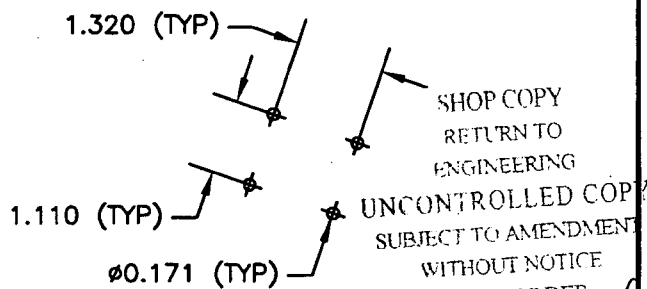


NOTE: ENSURE THAT CUTOUT IS PERPENDICULAR TO EDGE OF DOOR

**DETAIL D**



**DETAIL E**



**DETAIL F**

**NOTES:**

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- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED  
06.12.22

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2699, 5ième Avenue  
Local 14, PORTE -A-  
Grand-Mère, Québec G9T 5K7  
Can \*\*Fax (819) 533-3494 \*\*

# PACKING SLIP CERTIFICATE OF COMPLIANCE

Invoice #	11809
Customer #	DART

Telephone: (819) 533-5788

Warehouse: MAIN

Bill to:

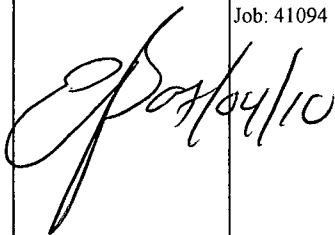
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1270, Aberdeen Street  
Hawkesbury, Ontario K6A 1K7  
Canada

Ship to:

Dart Aerospace Ltd.  
1270, Aberdeen Street  
Hawkesbury, Ontario K6A 1K7  
Canada

Telephone: 613-632-3336

Contact: Linda Lacelle

Ship via		F.O.B.		Terms		Salesperson	
EPIC EXPRESS COLLECT		Origin		Net30 days		Claude Lessard, ext. 233	
Ship date	Order Date	Our PO #	Order by		Your PO #	GST/PST #	
04/04/07	21/12/06	5092	C. Lavoie		PO00002767		
Order Qty	B.O. Qty	Current Ship	Item #	Item Description			
1	0	1	DKC134-0052	D3186-1M Spacepod Door LH B30014 Dwg. Rév.: C Job: 41247 U de M : Each			
1	0	1	DKC134-0053	D3188-1M Spacepod Body LH B30024 Dwg. Rév.: C Job: 41093 U de M : Each			
1	0	1	DKC134-0054	D3186-2M Spacepod Door RH B30034 Dwg. Rév.: C Job: 41249 U de M : Each			
1	0	1	DKC134-0055	D3188-2M Spacepod Body RH B30044 Dwg. Rév.: C Job: 41094 U de M : Each			
							

*Post 04/10*

It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request.

☒ Cust. ☐ Adm. ☐ Quality ☐ Ship.

Accepted by:

Quality department

AQ-357



Date: Jeudi, 2007-03-22 15:15:45  
 Rédacteur: Marc Dubé

## Feuille de Procédé

Client :	DART Dart Aerospace Ltd.	Nom Dessin :	SPACEPOD DOOR
Numéro Job :	41249	Numéro Article :	DKC134-0054
Numéro Soumission :	2586	Numéro Dessin :	D3186
Numéro B.A. :		Projet Numéro :	DKC134
Date fois :	2007-03-22 No. B.V. :	Révision dessin :	C
Dernière Rev. :	NC	Matériel :	Fibre 7781 et Résine 411-35
Rem. fois :	-- Type :	Date Dûe :	2007-03-29 Qté: 1 Udm: UNITE
Objet précédente :	41119		
Écrit par :			
Vérifié & Approuvé par :			
Commentaires :	N° de pièce Dart Aerospace : D31862M		



Process Sheet Rev.: 01 Modification générale selon les informations de l'ingénierie.

Produit additionnel

Numéro Job:



# Séq.: Machine ou Opération: Description :

1.0 AC0303 Frekote 44NC

 Commentaire Qty.: 0.020 GALLON(s)/Unit Total : 0.020 GALLON(s)  
 Frekote 44NC

2.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART


 Commentaire Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs  
 PRÉPARATION DU MOULE

Faire la préparation du moule N° DT 8005 à l'aide de Frekote 44NC et laisser sécher pendant 3 heures selon le QSI-006.

Date: 20/03/07 Heure Début: 8:00 Heure Fin: 11:00 Sceau:



3.0 AC0409 Tissu à délaminer Release ply B

 Commentaire Qty.: 3.28 VERGE(s)/Unit Total : 3.28 VERGE(s)  
 Tissu à délaminer Release ply B

4.0 AC0407 Wrightlon 5200 Bleu P3

 Commentaire Qty.: 3.59 VERGE(s)/Unit Total : 3.59 VERGE(s)  
 Wrightlon 5200 Bleu P3

5.0 AC0408 Feutre de drainage N° Airweave N 10

 Commentaire Qty.: 3.00 VERGE(s)/Unit Total : 3.00 VERGE(s)  
 Feutre de drainage N° Airweave N 10

6.0 AC0752 Stretchlon 200 poche à vide Vert








 Commentaire Qty.: 3.00 VERGE(s)/Unit Total : 3.00 VERGE(s)  
 Stretchlon 200 poche à vide Vert



Date: Jeudi, 2007-03-22 15:45










Utilisateur: Marc Dubé

## Feuille de Procédé

Client: DART Aerospace Ltd.	Nom Dessin: SPACEPOD DOOR	
Numéro Job: 41249	Numéro Article: DKC134-0054	
Numéro Job:		
# Séq.: 7.0	Machine ou Oération: AACC681	Description: 9.7 oz Weave #FG-778150-125Y Volan Finish
Commentaire Qty.: 4.500 VERGE(s)/Unit Total: 4.500 VERGE(s) 9.7 oz Weave #FG-778150-125Y Volan Finish 1-6030-1		
8.0	AACC443	Fiberglass 12 oz Unidirectional
Commentaire Qty.: 1.00 VERGE CAR(s)/Unit Total: 1.00 VERGE CAR(s) Fiberglass 12 oz Unidirectional N° de Lot: 5935		
9.0	AC0098	Ruban à gommer jaune #: T/AT-200Y
Commentaire Qty.: 2.2500 RL(s)/Unit Total: 2.2500 RL(s) Ruban à gommer jaune #: T/AT-200Y		
10.0	PRÉPARATION 3	PRÉPARATION DU MATÉRIEL DART
 		
Commentaire Setup: 0.00 Hrs/ Run: 30.0000Min Total Run: 0.5000Hrs TAILLAGE DU MATÉRIEL  Tailler le matériel, selon les différents patrons de découpe:  Appliquer le Ruban jaune tout le tour du stretchlon 200 en laissant le papier sur le coté non en contact avec le sac à vide.  Afin d'accélérer le processus de taillage, tailler les plis de 9.7 oz tous en même temps en les superposants les uns sur les autres.  Date: 16/03/07 Heure Début: 3:45 Heure Fin: 4:30 Sceau: 		
11.0	AAC0275	Catalyst N° DDM-9
Commentaire Qty.: 0.0640 PINTE(s)/Unit Total: 0.0640 PINTE(s) Catalyst N° DDM-9 N° de Lot: 5927		
12.0	AAC0324	Résine (411B7530) 411-350 promo. 75min.
Commentaire Qty.: 0.500 KILOGRAMME(s)/Unit Total: 0.500 KILOGRAMME(s) Résine (411 B7530) 411-350 promo. 75min N° de Lot: 1-6032-1		
13.0	PRÉPARATION 3	PRÉPARATION DU MATÉRIEL DART
 		
Commentaire Setup: 0.00 Hrs/ Run: 5.0000Min Total Run: 0.0833Hrs PRÉPARATION DU MATÉRIEL  Faire la préparation de la résine selon les quantités requises, mix ratio 1.5% de Catalyst N° DDM-9 par quantité de résine N° 411-350.  Date: 21/03/07 Heure Début: 10:15 Heure Fin: 10:45 Sceau: 		

Utilisateur: Marc Dubé

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.		Nom Dessin: SPACEPOD DOOR	
Numéro Job: 41249		Numéro Article: DKC134-0054	
Numéro Job:			
# Séq.:	Machine ou Opération:	Description :	
14.0	LAMINAGE.	LAMINAGE PIÈCE DART	
			
<p>Commentaire Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs FAIRE LE LAMINAGE DES TISSUS</p> <p>À l'aide d'un rouleau 2" dia. appliquer une couche de résine N° 411-350 sur le moule N° DT 8004 et en suite imbiber un pli de tissu 9.7oz.</p> <p>Recommencer l'opération pour le deuxième pli.</p> <p>Date: <u>21/03/07</u> Heure Début: <u>10:45</u> Heure Fin: <u>11:15</u> Sceau:  </p>			
15.0	POCHE À VIDE 1	FAIRE LA POCHE À VIDE	
			
<p>Commentaire Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs EFFECTUER LA POCHE A VIDE</p> <p>Faire la poche à vide en appliquant les composantes dans l'ordre suivant:</p> <ol style="list-style-type: none"> <li>1- Tissu à délaminer,</li> <li>2- Film perforé P-3,</li> <li>3- Feutre de drainage</li> <li>4- Sac à vide Stretchlon 200</li> </ol> <p>Laisser sécher pendant 4 heures minimum.</p> <p>Date: <u>21/03/07</u> Heure Début: <u>11:15</u> Heure Fin: <u>11:30</u> Sceau:  </p> <p>Curing Début: <u>11:30</u> Curing Fin: <u>4:15</u></p>			
16.0	AAC0275	Catalyst N° DDM-9	
<p>Commentaire Qty.: 0.0120 PINTÉ(s)/Unit Total : 0.0120 PINTÉ(s) Catalyst N° DDM-9</p> <p>N° de Lot: <u>5921</u></p>			
17.0	AAC0324	Résine (411B7530) 411-350 promo. 75min.	
<p>Commentaire Qty.: 0.300 KILOGRAMME(s)/Unit Total : 0.300 KILOGRAMME(s) Résine (411B7530) 411-350 promo. 75min.</p> <p>N° de Lot: <u>1-6032-1</u></p>			

## Feuille de Procédé

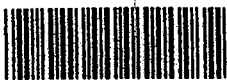
Client: DART Dart Aerospace Ltd.

Nom Dessin: SPACEPOD DOOR

Numéro Job: 41249

Numéro Article: DKC134-0054

Numéro Job:



# Séq.: Machine ou Opération: Description :

18.0

PRÉPARATION 3

PRÉPARATION DU MATÉRIEL DART



Commentaire Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs

PRÉPARATION DU MATÉRIEL

Faire la préparation de la résine selon les quantités requises, mix ratio 1.5% de Catalyst N° DDM-9 par quantité de résine N° 411-350 Imbiber toutes les surfaces du foam core.

Laisse sécher pendant 2 heures.

Date: 21/03/07 Heure Début: 9:30 Heure Fin: 9:45 Sceau: 

19.0

AAC0452

Polybond B46F

Commentaire Qty.: 0.082 KIT(s)/Unit Total : 0.082 KIT(s)

Polybond B46F

N° de Lot:

1-5865-1

20.0

DKC134-0057

Foam Core N° D3186-102 ( Porte D3186-2 )

Commentaire Qty.: 1 UNITE(s)/Unit Total : 1 UNITE(s)

Foam Core N° D3186-102 ( Porte D3186-2 )

1-5826-1

21.0

ASSEMBLAGE 3

ASSEMBLAGE GÉNÉRALE DART



Commentaire Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs

ASSEMBLAGE GÉNÉRALE DES PIÉCES

Retirez le bagging.

Pour aider au positionnement du 12 oz., positionner le gabarit de trimage dans le moule et tracer son contour sur le 9 oz.. Retirer le gabarit de trimage.

Positionner le foam core à l'aide du gabarit prévu à cet effet et tracer son contour sur le 9 oz. ( Vous devriez maintenant avoir 2 contours de tracé sur le 9 oz. )

Appliquer une couche de Polybond B64F à l'endos du Foam Core N° DKC134-0057 et positionner le foam Core sur le moule selon le dessin, et selon les lignes de positionnement prévues à cet effet.

Date: 22/03/07 Heure Début: 10:30 Heure Fin: 11:00 Sceau:   

22.0

POCHE À VIDE 1

FAIRE LA POCHE À VIDE



Commentaire Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs

EFFECTUER LA POCHE A VIDE

Faire la poche à vide en appliquant les composantes dans l'ordre suivant:

1- Tissu à délaminer

2- Feutre de drainage

Date: Jeudi, 2007-03-22 15:15:45

Utilisateur: Marc Dubé

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.  
Numéro Job: 41249Nom Dessin: SPACEPOD DOOR  
Numéro Article: DKC134-0054

Numéro Job:




# Séq.: Machine ou Opération: Description :

3- Sac à vide Stretchlon 200

Laisser sécher pendant 2 heures minimum.

Retirez le bagging avant la fin de la polymérisation ( entre 1 heure et 1heure 1/2 ) afin d'enlever le surplus de polybond

Date: 22/03/07 Heure Début: 11:00 Heure Fin: 11:15 Sceau:   

Curing Début: 11:15 Curing Fin: 12:40

23.0 AAC0275 Catalyst N° DDM-9

Commentair Qty.: 0.0400 PINTE(s)/Unit Total : 0.0400 PINTE(s)

Catalyst N° DDM-9

N° de Lot: 5921

24.0 AAC0324 Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 1.000 KILOGRAMME(s)/Unit Total : 1.000 KILOGRAMME(s)

Résine (411B7530) 411-350 promo. 75min.

N° de Lot: 1-6032-1

25.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART

Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs  
PRÉPARATION DU MATÉRIEL

Faire la préparation de la résine selon les quantité requises, mix ration 1.5% de Catalyst N° DDM-9 par quantité de résine N° 411-350.

Date: 23/03/07 Heure Début: 12:30 Heure Fin: 12:45 Sceau: 

26.0 LAMINAGE. LAMINAGE PIÈCE DART





Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs

FAIRE LE LAMINAGE DES TISSUS

Faire le laminage d'un pli de 9.7 oz.

Faire le laminage du pli de tissu de 12 oz tout le tour de la porte.

Faire le laminage du dernier pli de 9.7 oz.

Date: 23/03/07 Heure Début: 12:45 Heure Fin: 1:40 Sceau:  

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: SPACEPOD DOOR

Numéro Job: 41249

Numéro Article: DKC134-0054

Numéro Job:



# Séq.: Machine ou Opération: Description :

27.0 POCHE À VIDE 1 FAIRE LA POCHE À VIDE



Commentaire Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs  
EFFECTUER LA POCHE A VIDE

Faire la poche à vide en appliquant les composantes dans l'ordre suivant:

- 1- Tissu à délaminer,
- 2- Film perforé P-3,
- 3- Feutre de drainage
- 4- Sac à vide Stretchlon 200

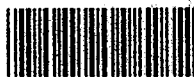
Laisser sécher pendant 4 heures minimum.

Date: 23/03/07 Heure Début: 1:40 Heure Fin: 2:00 Sceau:



Curing Début: 2:00 PM Curing Fin: 8:00 AM

28.0 DÉMOULAGE 1 DÉMOULAGE PIÈCE DART



Commentaire Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs  
DÉMOULAGE DES PIÈCES

Démouler la pièce en faisant bien attention de ne pas abimer les coins et le " edges ".

Sabler la surface de la pièce qui était en contact avec le moule afin d'éliminer le fini lisse de celui-ci.

Date: 27/03/07 Heure Début: 8:00 Heure Fin: 8:15 Sceau:



29.0 TRIMAGE 3 TRIMAGE COMPOSITES DART



Commentaire Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs  
TRIMAGE DE FINITION

Trimer les contour de la pièce l'aide du gabarit de trimage prévu à cet effet.

Date: 27/03/07 Heure Début: 9:00 Heure Fin: 9:40 Sceau:



30.0 AAC0671 Dupont Primer N° 1104S

Commentaire Qty.: 0.1390 GALLON(s)/Unit Total: 0.1390 GALLON(s)  
Dupont Primer N° 1104S

N° de Lot: 1-5931-2

Date: Jeudi, 2007-03-22 15:15:46

Utilisateur: Marc Dubé

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: SPACEPOD DOOR

Numéro Job: 41249

Numéro Article: DKC134-0054

Numéro Job:



# Séq.: Machine ou Opération: Description:

31.0 AAC0670 Dupont Activator N° 7975S

Commentair Qty.: 0.2800 PINTE(s)/Unit Total: 0.2800 PINTE(s)  
Dupont Activator N° 7975S

N° de Lot: 1-6041-1

32.0 AAC0672 Dupont Reducer N° 12375S

Commentair Qty.: 0.0350 GALLON(s)/Unit Total: 0.0350 GALLON(s)  
Dupont Reducer N° 12375S

N° de Lot: 1-5390-2

33.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART

Commentair Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run: 0.0000Hrs  
PRÉPARATION DU MATÉRIEL DART

MAR 28 2007



Bien brasser les trois contenants servant à faire le mélange du primer gris N° 1104S et ensuite faire le mélange selon les instruction du fabriquant.

34.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART

Commentair Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run: 0.0000Hrs  
PRÉPARATION DU MATÉRIEL DARTAppliquer une première couche de primer Dupont N° 1104S ( 7975S Activator, 12375S Reducer ) Se on I.G.  
# Application primer

Laisser sécher pendant 3 heures.

MAR 28 2007

Heure Début: \_\_\_\_\_ Heure Fin: \_\_\_\_\_ Sceau: \_\_\_\_\_



35.0 FINITION 3 FINITION PIÈCE DART

Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs  
FINITION PIÈCE DART

Faire le sablage de la pièce à l'aide de papier sablé grit 220 afin de corriger les imperfection et enlever le lustre du primer.

Date: Jeudi, 2007-03-22 15:15:46

Utilisateur: Marc Dubé

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: SPACEPOD DOOR

Numéro Job: 41249

Numéro Article: DKC134-0054

Numéro Job:



# Séq.: Machine ou Opération: Description:

36.0 AC0058 Polysoft 1.3 kg # 003012 Sikkens

Commentair Qty.: 0.050 UNITE(s)/Unit Total: 0.050 UNITE(s)  
Polysoft 1.3 kg # 003012 Sikkens

N° de Lot: 1-6044-1

37.0 AC0059 Durcisseur Polysoft #004009 Sikkens

Commentair Qty.: 0.039 UNITE(s)/Unit Total: 0.039 UNITE(s)  
Durcisseur Polysoft #004009 Sikkens

38.0 FINITION 3 FINITION PIÈCE DART

Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run: 0.1667Hrs  
FINITION GÉNÉRALE

Faire les réparations de finition s'il y a lieu, à l'aide de Sikkens.

Date: 27-3-07 Heure Début: \_\_\_\_\_ Heure Fin: \_\_\_\_\_ Sceau:

39.0 AAC0671 Dupont Primer N° 1104S

Commentair Qty.: 0.1390 GALLON(s)/Unit Total: 0.1390 GALLON(s)  
Dupont Primer N° 1104S N° de Lot: 1-59312

40.0 AAC0670 Dupont Activator N° 7975S

Commentair Qty.: 0.2800 PINTE(s)/Unit Total: 0.2800 PINTE(s)  
Dupont Activator N° 7975S N° de Lot: 1-6041-1

41.0 AAC0672 Dupont Reducer N° 12375S

Commentair Qty.: 0.0350 GALLON(s)/Unit Total: 0.0350 GALLON(s)  
Dupont Reducer N° 12375S N° de Lot: 1-5390-2

42.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART

Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run: 0.2500Hrs  
PRÉPARATION DU MATÉRIEL

APR 02 2007



Bien brasser les trois contenants servant à faire le mélange du primer gris N° 1104S et ensuite faire le mélange selon les instructions du fabricant.

43.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART

Commentair Setup: 0.00Hrs/ Run: 20.0000Min Total Run: 0.3333Hrs  
APPLICATION DE PRIMERAppliquer une deuxième couche de primer Dupont N° 1104S ( 7975S Activator, 12375S Reducer ) Selon I.G.  
# Application de primer.

APR 02 2007

Date: \_\_\_\_\_ Heure Début: \_\_\_\_\_ Heure Fin: \_\_\_\_\_ Sceau:

Date: Jeudi, 2007-03-22 15:11:46

Opérateur: Marc Dubé

## Feuille de Procédé

Client: DART

Dart Aerospace Ltd.

Nom Dessin: SPACEPOD DOOR

Numéro Job: 41249

Numéro Article: DKC134-0054

Numéro Job:



# Séq.:

Machine ou Opération:

Description :

44.0

INSPECTION 3

INSPECTION PIÈCE DART



Commentaire Setup: 0.00Hr / Run: 0.0000Min Total Run: 0.0000Hrs

INSPECTION PIÈCE DART

1 PIÈCE 4-4-07



Emballage QT 1 4 avril 07





Date: Monday, 4/16/2007 2:25:17 PM  
User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SPACEPOD DOOR RH
Job Number	: 31769B01		
Estimate Number	: 12599		
P.O. Number	:	Part Number	: D31862M
This Issue	: 4/16/2007 S.O. No. :	Drawing Number	: D3186 REV.D
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : SMALL /MED FAB	Drawing Revision	: D
Previous Run	: 31812B01	Material	:
Written By	:	Due Date	: 5/5/2007 Qty: 1 Um: Each
Checked & Approved By	:		
Comment	: Est Rev:A New Issue 06-12-04 ec est rev B rev D dwg 07.03.07 ec		

### Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	PG	PURCHASING
-----	----	------------



Comment: PURCHASING

Issue P/O: \_\_\_\_\_

Description: D3186-2M Door

Supplier: Delastek

Conformity Certificate and Process sheet required

Ship 3 Items from Previous steps

*w/o 30034*

2.0	D31862P	Spacepod Door
-----	---------	---------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
Spacepod Door

3.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Receive and inspect for transit damage.Ensure a copy of certification of conformity and process sheet from Delastek is attached.

4.0	QC6	DIMENSIONAL CHECK
-----	-----	-------------------



Comment: DIMENSIONAL CHECK

Inspect dimensions as per Dwg.D3186. Visual inspection. -Check for void spot and pins.

5.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 4/16/2007 2:25:17 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD DOOR RH

Job Number: 31769B01

Part Number: D31862M

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



*LY 07-04-27*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**DART**

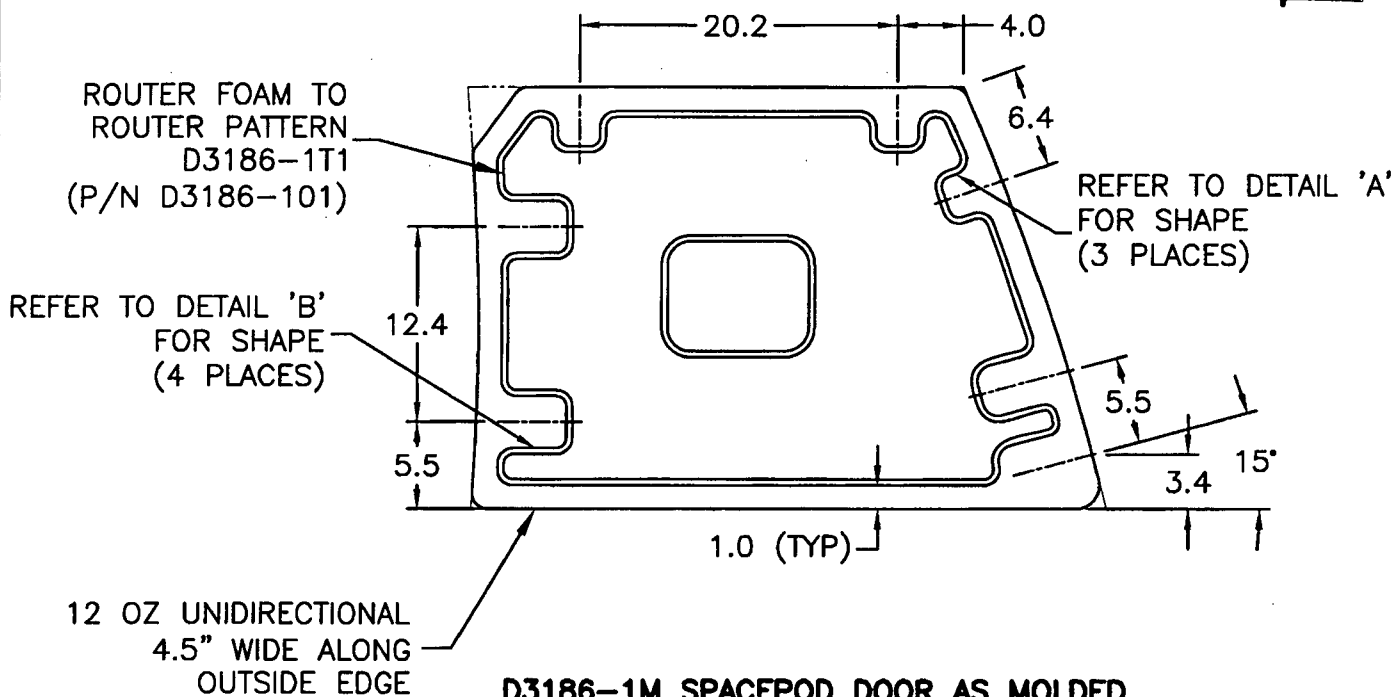
DESIGN DS	DRAWN BY LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED B	APPROVED H	DRAWING NO. D3186	REV. D SHEET 1 OF 5
DATE 07.02.22	TITLE SPACEPOD DOOR		SCALE NTS
A	03.03.27	NEW ISSUE	
B	06.09.25	DIMS UPDATED TO MATCH PRODUCT FOAM PATTERN UPDATED D3186-1M/-2M/-3/-4 ADDED	
C	06.12.13	REMOVED D0600-XXX LABELS	
D	07.02.22	UPDATE DIMENSIONS	

**MAIN LAYUP**

9 OZ SATIN (9 SQ FEET)  
9 OZ SATIN (9 SQ FEET)  
FOAM  
9 OZ SATIN (9 SQ FEET)  
12 OZ UNIDIRECTIONAL  
9 OZ SATIN (9 SQ FEET)  
RESIN (35-45% BY WEIGHT)  
PEEL PLY

**RELEASED**

07.02.27 H

**D3186-1M SPACEPOD DOOR AS MOLDED****NOTES:**

- 1) USE MOLD DT8005 FOR DOOR LAYUP
- 2) RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
- 3) FOAM: 3/8", A500 CORE-CELL OR DIVINYLCELL OR AIREX OR KLEGECELL
- 4) FIBRE: 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")  
12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
- 5) LAMINATE PER DART QSI 006 4.0
- 6) LAMINATION SCHEDULE PER THIS DRAWING
- 7) FINISH INSIDE/OUTSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S
- 8) ALL DIMENSIONS ARE IN INCHES
- 9) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE

WORK ORDER  
NO. 31769B01

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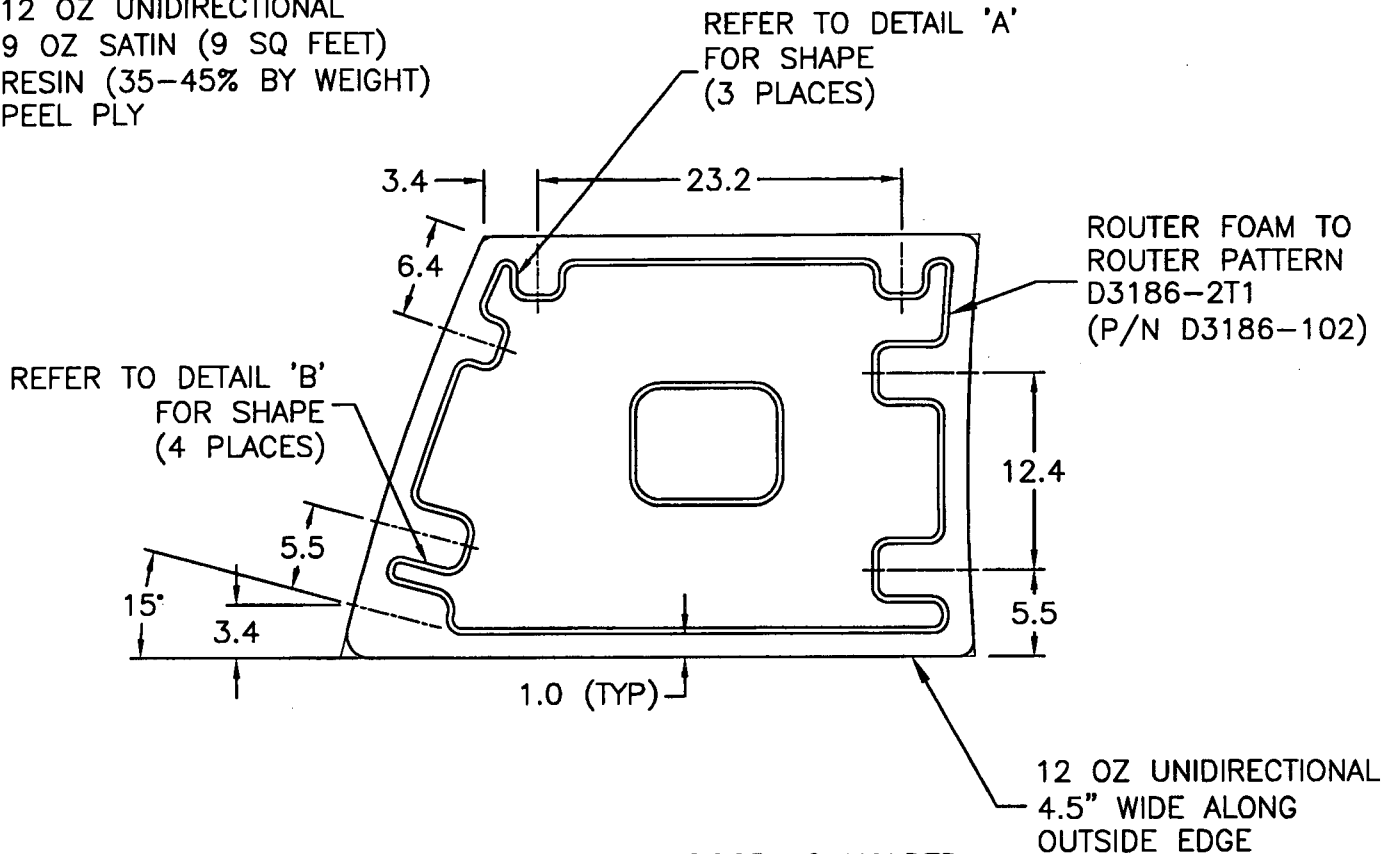
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CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3186	REV. D SHEET 2 OF 5
DATE 07.02.22	TITLE SPACEPOD DOOR		SCALE NTS

**MAIN LAYUP**

9 OZ SATIN (9 SQ FEET)  
9 OZ SATIN (9 SQ FEET)  
FOAM  
9 OZ SATIN (9 SQ FEET)  
12 OZ UNIDIRECTIONAL  
9 OZ SATIN (9 SQ FEET)  
RESIN (35-45% BY WEIGHT)  
PEEL PLY

**RELEASED**

07.02.27 [Signature]

**D3186-2M SPACEPOD DOOR AS MOLDED****NOTES:**

- 1) USE MOLD DT8006 FOR DOOR LAYUP
- 2) RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
- 3) FOAM: 3/8", A500 CORE-CELL OR DIVINYCELL OR AIREX OR KLEGECELL
- 4) FIBRE: 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")  
12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
- 5) LAMINATE PER DART QSI 006 4.0
- 6) LAMINATION SCHEDULE PER THIS DRAWING
- 7) FINISH INSIDE/OUTSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S
- 8) ALL DIMENSIONS ARE IN INCHES
- 9) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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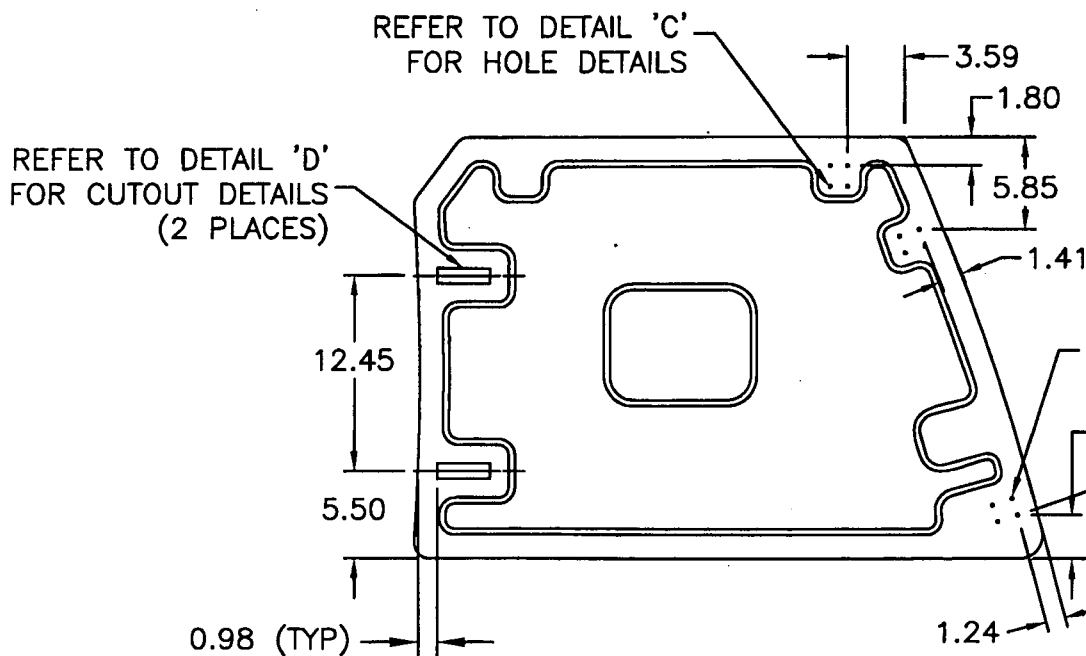
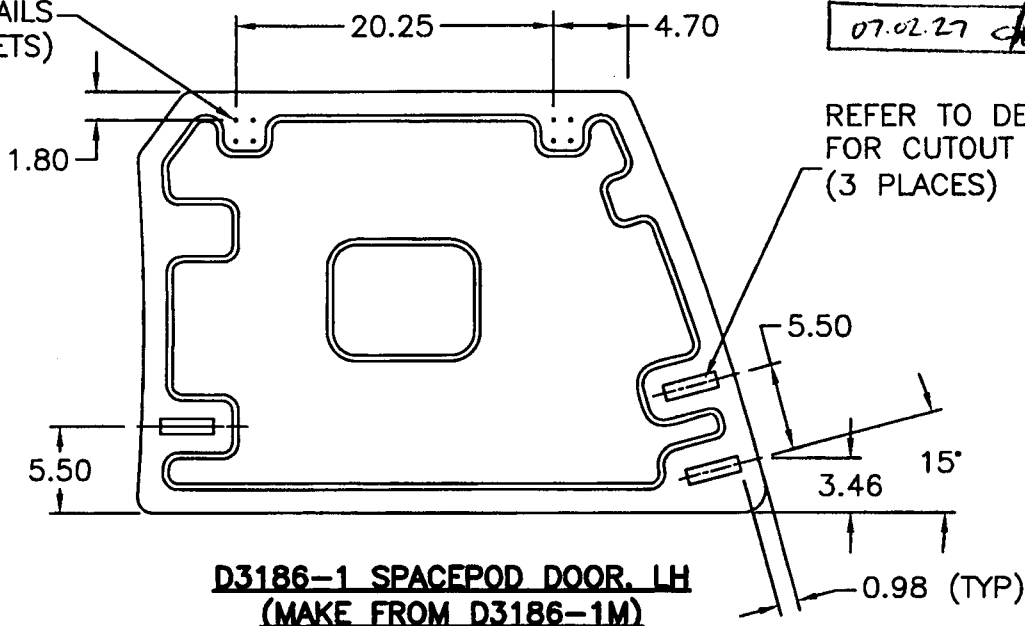
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DATE 07.02.22		TITLE SPACEPOD DOOR	SCALE NTS

REFER TO DETAIL 'C'  
FOR HOLE DETAILS  
(2 SETS)



**D3186-3 SPACEPOD DOOR, LH**  
**(MAKE FROM D3186-1M)**

**NOTES:**

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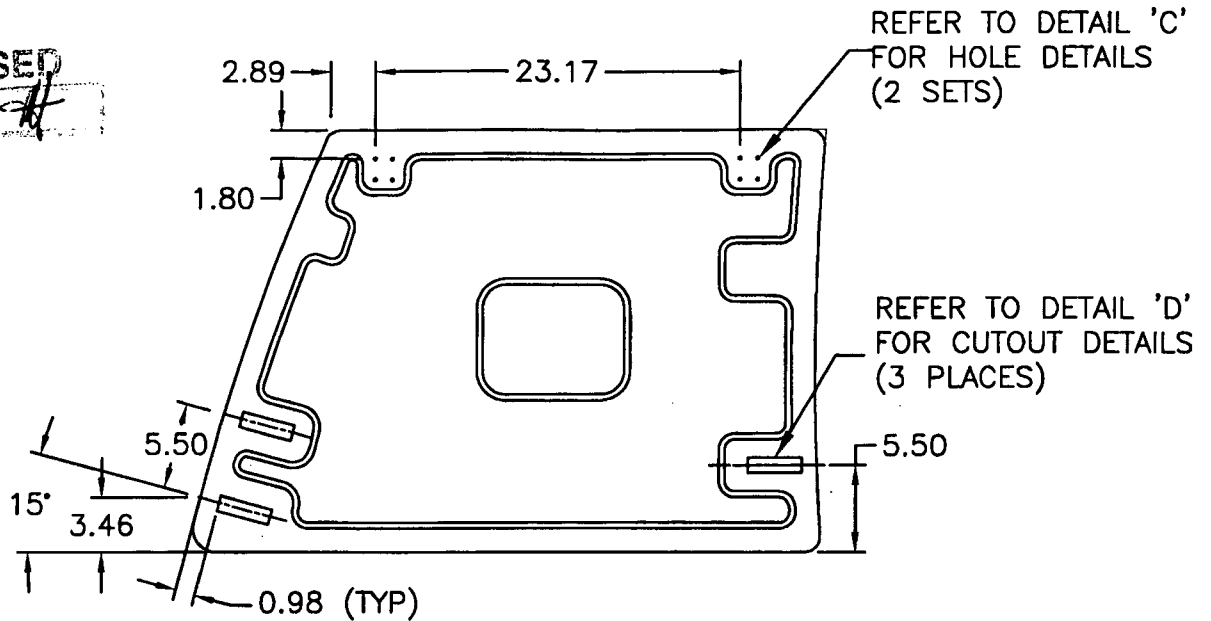
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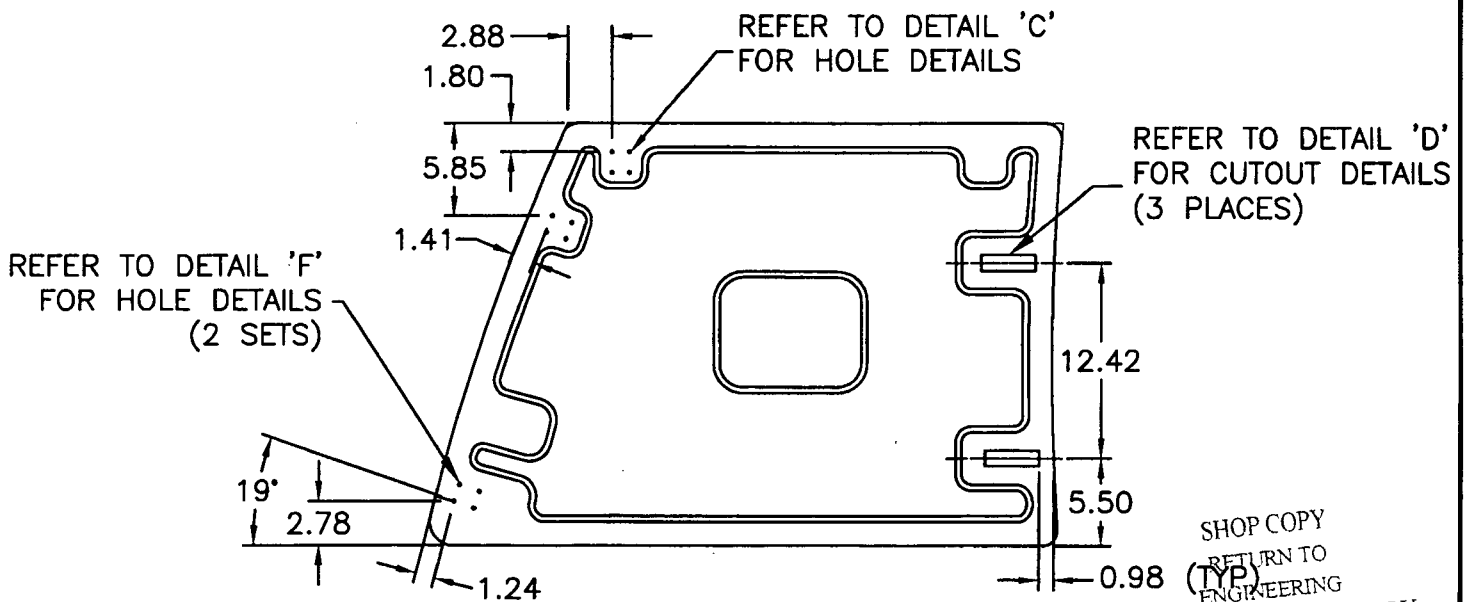
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DATE 07.02.22	TITLE SPACEPOD DOOR		SCALE NTS

**RELEASED**

07-02-27



**D3186-2 SPACEPOD DOOR, RH**  
**(MAKE FROM D3186-2M)**



**D3186-4 SPACEPOD DOOR, RH**  
**(MAKE FROM D3186-2M)**

**NOTES:**

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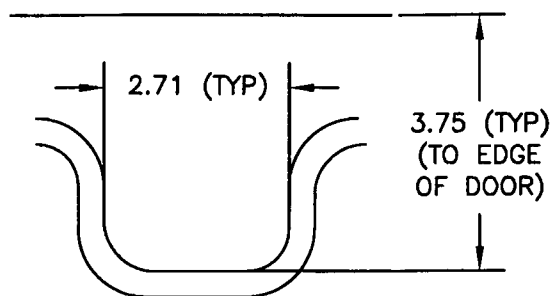
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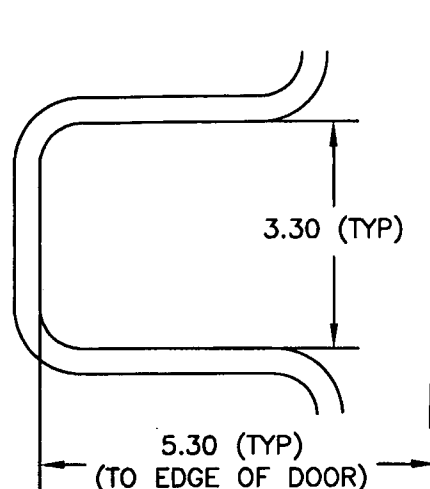




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DATE 07.02.22	TITLE SPACEPOD DOOR		SCALE NTS



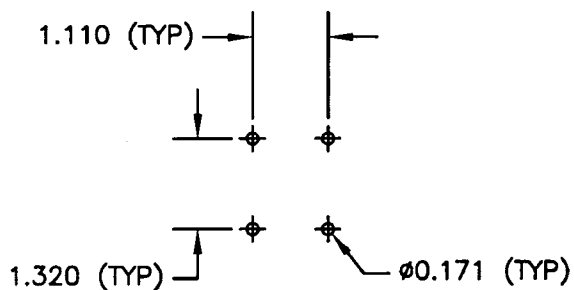
**DETAIL A**



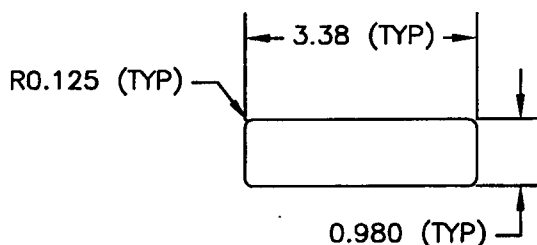
**DETAIL B**

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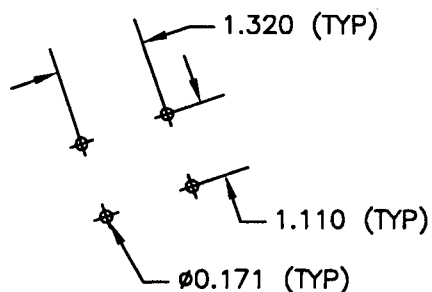


**DETAIL C**

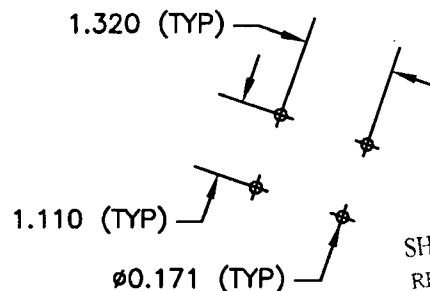


NOTE: ENSURE THAT CUTOUT IS PERPENDICULAR TO EDGE OF DOOR

**DETAIL D**



**DETAIL E**



**DETAIL F**

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